



# 18" HEAVY-DUTY BANDSAW

## MODEL G1012

# INSTRUCTION MANUAL



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# WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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# SECTION 1: SAFETY


## WARNING

### For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

 **DANGER** Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

 **WARNING** Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

**NOTICE** This symbol is used to alert the user to useful information about proper operation of the equipment.

## WARNING

### Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT.** Do not use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.

# ⚠️ **WARNING**

## **Safety Instructions For Power Tools**

- 9. USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

| AMP RATING | LENGTH |      |       |
|------------|--------|------|-------|
|            | 25ft   | 50ft | 100ft |
| 0-6        | 18     | 16   | 16    |
| 7-10       | 18     | 16   | 14    |
| 11-12      | 16     | 16   | 14    |
| 13-16      | 14     | 12   | 12    |
| 17-20      | 12     | 12   | 10    |
| 21-30      | 10     | 10   | No    |

- 10. WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 11. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.
- 13. DO NOT OVERREACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

- 15. USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

- 16. REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

- 17. MANY WOODWORKING TOOLS CAN "KICKBACK" THE WORKPIECE** toward the operator if not handled properly. Know what conditions can create "kickback" and know how to avoid them. Read the manual accompanying the machine thoroughly.

- 18. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

- 19. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

- 20. NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

- 21. NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

## **WARNING**

# **Additional Safety Instructions For Bandsaws**

- 1. DO NOT OPERATE WITH DULL OR BADLY WORN BLADES.** Dull blades require more effort to use and are difficult to control. Inspect blades before each use.
- 2. NEVER POSITION FINGERS OR THUMBS IN LINE WITH THE CUT.** Serious personal injury could occur.
- 3. DO NOT OPERATE THIS BANDSAW WITHOUT WHEEL, PULLEY, AND BLADE GUARDS IN PLACE.**
- 4. WHEN REPLACING BLADES,** make sure the teeth face down toward the table. The force of the cut is always down. Make sure the blade is properly tensioned.
- 5. CUTS SHOULD ALWAYS BE FULLY SUPPORTED** by the table or some type of support fixture. Always support round stock in a V-block.
- 6. DO NOT BACK WORKPIECE AWAY** from the blade while the saw is running. Plan your cuts so you always cut out of the wood. If you need to back the work out, turn the bandsaw off and wait for the blade to come to a complete stop. Do not twist or put excessive stress on the blade while backing work away.
- 7. ALWAYS FEED STOCK EVENLY AND SMOOTHLY.** Do not force or twist blade while cutting, especially when sawing small radii.
- 8. THIS MACHINE IS NOT DESIGNED TO CUT METAL** or other material except wood.
- 9. BLADE SHOULD BE RUNNING AT FULL SPEED** before beginning a cut.
- 10. DO NOT MANUALLY STOP OR SLOW BLADE** after turning the saw off. Allow it to come to a complete stop before you leave it unattended.
- 11. ALL INSPECTIONS, ADJUSTMENTS, AND MAINTENANCE ARE TO BE DONE WITH THE POWER OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.
- 12. HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.
- 13. IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.

## **WARNING**

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use the Model G1012 18" Bandsaw will be time well spent. **DO NOT** operate this machine until you are completely familiar with the contents of this manual or serious personal injury may occur.

## **CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment or poor work results.

# SECTION 2: CIRCUIT REQUIREMENTS

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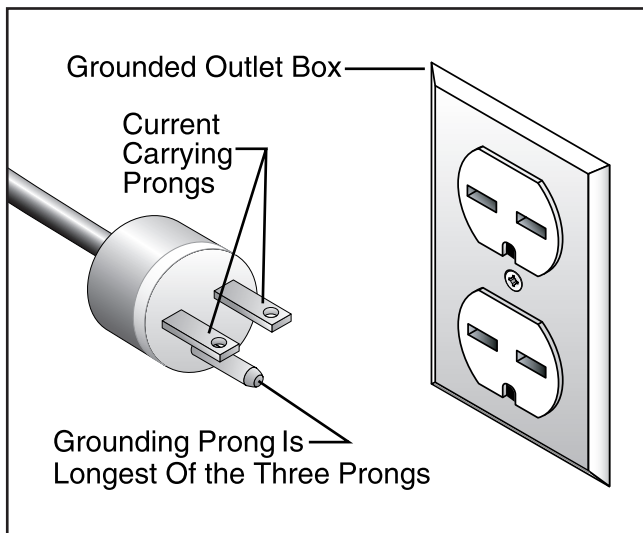
## 220V Operation

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The Model G1012 has a 2 H.P. motor which operates at 220V. If you do not intend to use a mobile base, you have the option of wiring this bandsaw directly to a dedicated circuit. However, you will need to have an in-line electrical disconnect located near the machine.

The Model G1012 motor will safely draw about 10 amps at 220V under load. If you operate the bandsaw on any circuit that is already close to its capacity, it might blow a fuse or trip a circuit breaker. However, if an unusual load does not exist, and the circuit breaker still trips, have the circuit inspected by a qualified electrician.



**Figure 1.** Typical 220V 3-prong plug and outlet.

### CAUTION

Be sure that your particular electrical configuration complies with local and state codes. The best way to ensure compliance is to check with your local municipality or licensed electrician.



## Fusing

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The Model G1012 should be fused at 15 amps. Fusing at amperage ratings higher than 15 amps may not adequately protect the circuit. Always make sure the plugs and wires in your circuit are never rated for less amperage than the circuit breaker you use.

In preparing to connect the Model G1012 to your existing or new circuit, it will be necessary to connect a plug that matches your 220V receptacle. If you will be installing a new receptacle and plug, we recommend a style similar to that shown in **Figure 1**. Note that you have the choice between simple plug-in and twist-lock plug styles. Whichever style you choose, be sure that both the plug and outlet are rated at 15 amps.



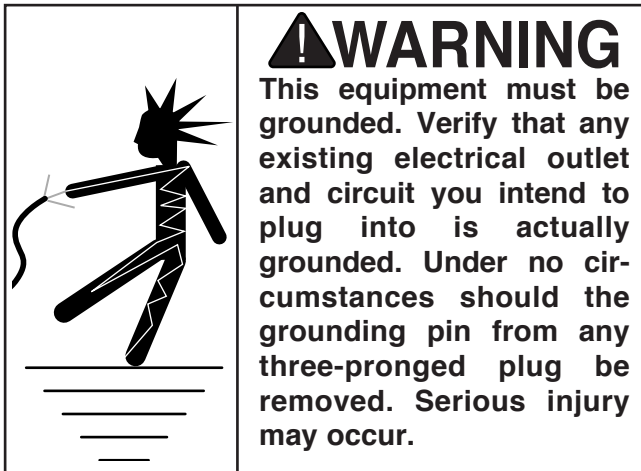
# Grounding

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In the event of a malfunction or breakdown, grounding provides electric current a path of least resistance to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment grounding conductor. A plug with a grounding pin must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor can result in the risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.



Under no circumstances should the grounding pin from any three-pronged plug be removed. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Check with a qualified electrician or one of our service personnel if the grounding instructions are not completely understood, or if you are in doubt as to whether the tool is properly grounded.

Repair or replace damaged or worn cords immediately.



# Extension Cords

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We do not recommend the use of extension cords on 220V equipment. It is much better to arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

If you must use an extension, make sure the cord is rated Hard Service (Grade S) or better. Refer to the chart in the safety instructions to determine the minimum gauge for the extension cord. Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-hole receptacles that accept the tool plug. Always repair or replace extension cords when they become worn or damaged.



## ⚠️ CAUTION

We have covered some basic electrical requirements for the safe operation of your bandsaw. These requirements are not necessarily comprehensive. You must be sure that your particular electrical configuration complies with local and state codes. Ensure compliance by checking with your local municipality or a licensed electrician.



# SECTION 3: GENERAL INFORMATION

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## Commentary

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Grizzly Industrial, Inc. is proud to offer the Model G1012 18" Heavy-Duty Bandsaw. This bandsaw is part of Grizzly's growing family of fine wood-working machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation, and proof of Grizzly's commitment to customer satisfaction.

This bandsaw features cast iron construction for rigidity and strength, a 3-speed pulley system and a 10" cutting height. It comes standard with stand, fence, miter gauge, guards, 1"-wide blade and an electrical package. The electrical package includes a 3450 R.P.M., 2 H.P. capacitor start motor, a magnetic safety switch and a cord set.

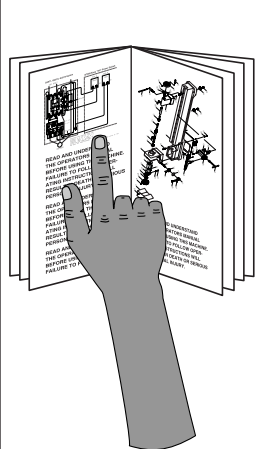
We are also pleased to provide this manual with the Model G1012. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any comments or criticisms that you feel we should address in our next printing, please write to us at:

Grizzly Industrial, Inc.  
% Technical Documentation  
P.O. Box 2069  
Bellingham, WA 98227

Most important, we stand behind our machines. We have excellent regional service departments at your disposal should the need arise. If you have any service questions or parts requests, please call or write to us at the location listed below.

Grizzly Industrial, Inc  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone:(570) 546-9663  
Fax:(800) 438-5901  
E-Mail: techsupport@grizzly.com  
Web Site: <http://www.grizzly.com>

The specifications, drawings, and photographs illustrated in this manual represent the Model G1012 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.

|  |   |
|--|---|
|  | <p><b>⚠ WARNING</b></p> <p><b>Read the manual before assembly and operation. Become familiar with the machine and its operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.</b></p> |
|--|---|




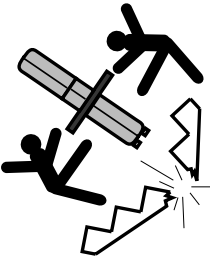
# Unpacking


The Model G1012 Bandsaw is shipped from the manufacturer in a carefully packed carton. If you discover the machine is damaged after you have signed for delivery, *please call Customer Service immediately for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory its parts.

|   |   |
|---|---|
|  | <p><b>⚠️ WARNING</b></p> <p>The Model G1012 is a heavy machine (456 lbs. shipping weight). <b>DO NOT over-exert yourself while unpacking or moving your machine – get assistance.</b></p> |
|---|---|

|   |   |
|---|---|
|  | <p><b>⚠️ WARNING</b></p> <p>If moving this machine up or down stairs, the machine must be dismantled and moved in smaller pieces. Make sure the stairs are capable of supporting the combined weight of the machine parts and the people moving them.</p> |
|---|---|

|   |   |
|---|---|
|  | <p><b>⚠️ CAUTION</b></p> <p>Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.</p> |
|---|---|



# Piece Inventory

After all the parts have been removed from the carton, you should have:

- Bandsaw Unit (see **Figure 2**)
- Stand Components (see **Figure 3**)
  - Top (1)
  - Legs (4)
  - Horizontal Braces (2)
  - Stand Sides (2)
  - Motor Bracket (1)
  - Pulley Cover (1)
- Other Bandsaw Components (see **Figure 4**)
  - Table
  - Motor
  - Miter Gauge
  - Fence
  - Fence Rails (2)
  - Trunnion Support Bracket
  - A31, A32, A33 V-Belts
  - Motor Pulley
  - Stepped Pulley
  - Wheel Pulley
  - Hardware Bags



**Figure 2.** Bandsaw unit.

# Hardware Bags

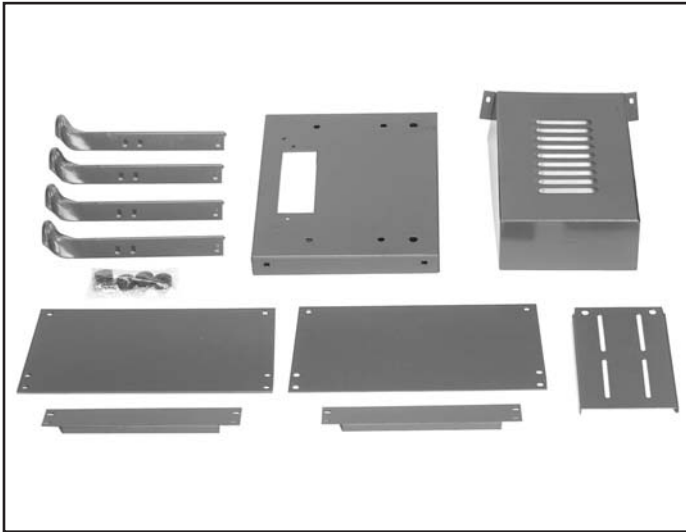


Figure 3. Stand components.



Figure 4. Bandsaw components.



| Inside Bags  | Qty |
|--|-----|
| Carriage Bolts $\frac{5}{16}$ " - 18 x $\frac{1}{2}$ "   | 24  |
| Flat Washers $\frac{5}{16}$ "                            | 40  |
| Nuts $\frac{5}{16}$ " - 18                               | 32  |
| Hex Head Bolts $\frac{5}{16}$ " - 18 x $\frac{3}{4}$ "   | 4   |
| Hex Head Bolts $\frac{5}{16}$ "-18 x 1"                  | 4   |
| Hex Head Bolts $\frac{1}{2}$ " - 12 x $1\frac{1}{2}$ "   | 4   |
| Hex Nuts $\frac{1}{2}$ " - 12                            | 4   |
| Flat Washers $\frac{1}{2}$ "                             | 8   |
| Cap Screws $\frac{1}{4}$ "-20 x $1\frac{1}{2}$ "         | 4   |
| Phillip Hd Screws $\frac{1}{4}$ " - 20 x $\frac{1}{2}$ " | 2   |
| Hex Nuts $\frac{1}{4}$ " - 20                            | 2   |
| Flat Washers $\frac{1}{4}$ "                             | 4   |
| Setscrews $\frac{1}{4}$ " x $\frac{1}{4}$ "              | 2   |
| Hex Bolts $\frac{3}{8}$ "-16 x $\frac{3}{4}$ "           | 2   |
| Hex Bolts $\frac{3}{8}$ "-16 x $1\frac{1}{4}$ "          | 2   |
| Hex Nuts $\frac{3}{8}$ "-16                              | 5   |
| Flat Washers $\frac{3}{8}$ "                             | 4   |
| Lock Nuts $\frac{3}{8}$ "                                | 4   |
| Hex Bolt $\frac{3}{8}$ "-16 x 3"                         | 1   |
| Hex Bolt $\frac{5}{8}$ "-11                              | 2   |
| Flat Washers $\frac{5}{8}$ "                             | 2   |
| Fence Rail Spacers                                       | 4   |
| 5 x 5 x 20mm Key   | 1   |
| Lock Knob (Male)   | 1   |
| Star Knobs (Female)                                      | 2   |
| Strain Relief w/Plastic Nut $\frac{1}{2}$ "              | 1   |
| 5mm Hex Wrench   | 1   |
| 3mm Hex Wrench   | 1   |
| Adjustment Bolts (w/Eye)                                 | 2   |
| Guide Blocks   | 8   |
| Thumbscrews $\frac{1}{4}$ "-20 x $\frac{1}{2}$ "         | 8   |
| Roll Pin 3 x 10mm  | 1   |
| Table Insert   | 1   |
| Rubber Feet  | 4   |

In the event that any non-proprietary parts are missing (e.g. nuts or washers), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

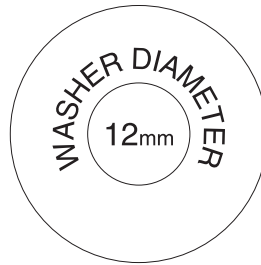
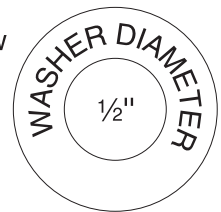
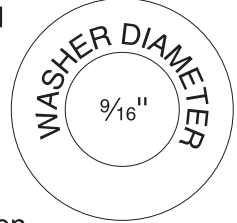
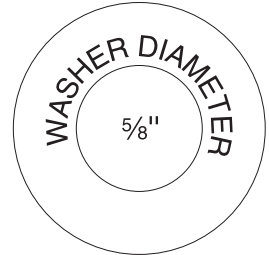
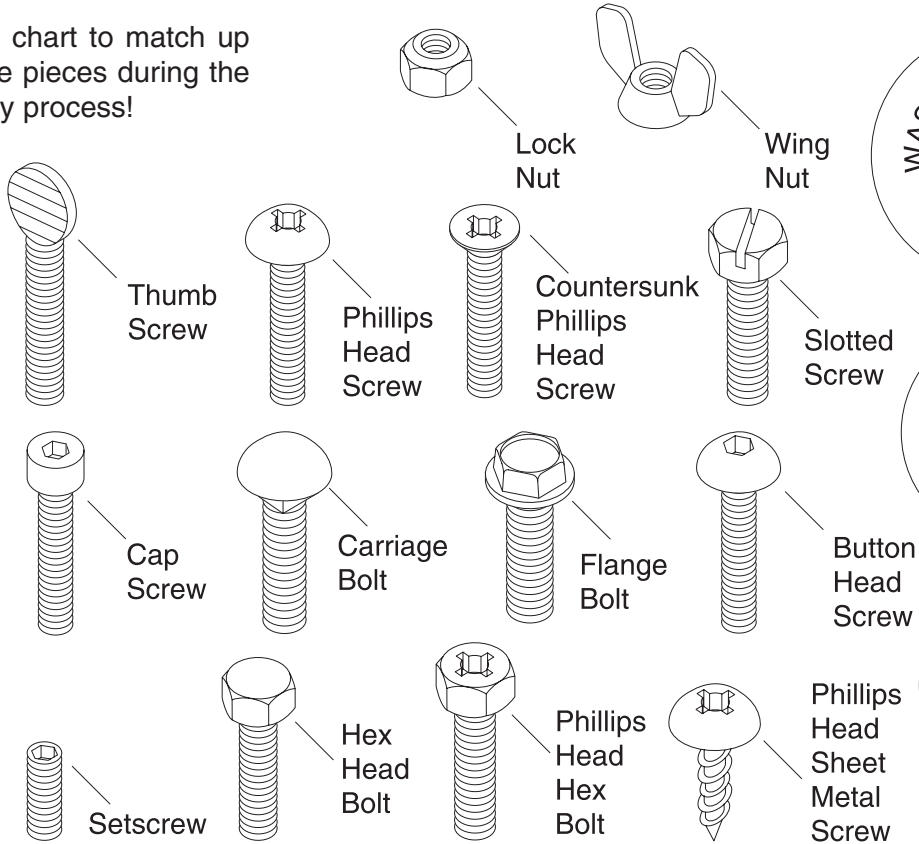


# Hardware Recognition Chart

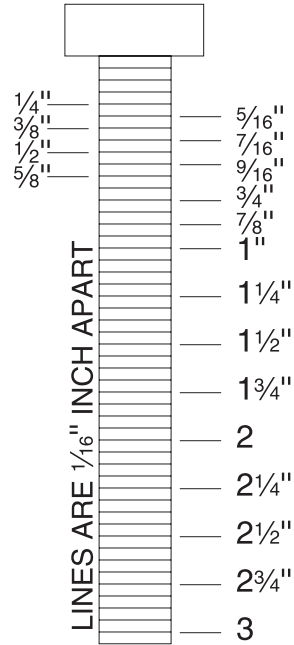
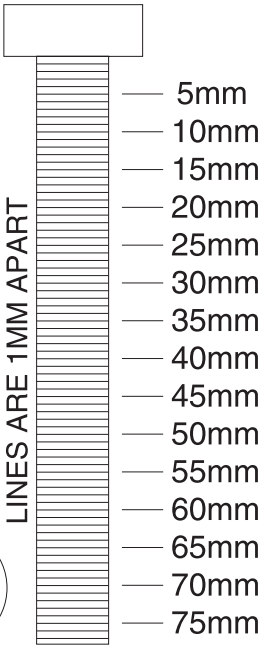
Use this chart to match up hardware pieces during the assembly process!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"




- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



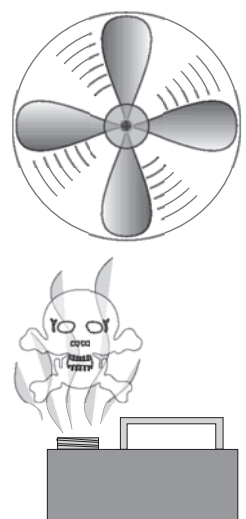
WASHERS ARE MEASURED BY THE INSIDE DIAMETER

# Clean up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the usage instructions on the product you choose for clean up.

|   |  |
|---|--|
|  | <p><b>⚠ WARNING</b><br/>Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur.</p> |
|---|--|

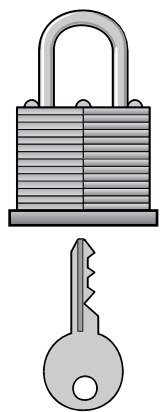
|   |  |
|---|--|
|  | <p><b>⚠ WARNING</b><br/>Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.</p> |
|---|--|

|   |   |
|---|---|
|  | <p><b>⚠ CAUTION</b><br/>Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.</p> |
|---|---|



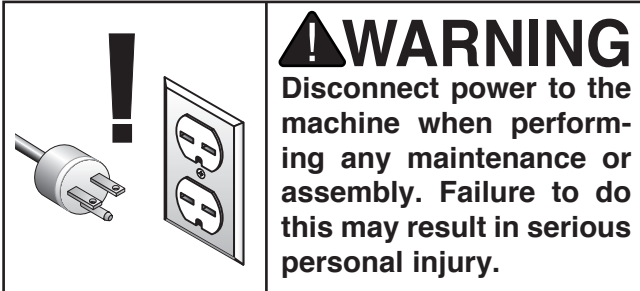
# Site Considerations

- **Floor Load:** Your Model G1012 18" Bandsaw represents a moderate weight load in a small footprint. Most commercial floors are suitable for the Model G1012. Some residential floors may require additional build up to support both machine and operator.
- **Working Clearances:** Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your bandsaw.
- **Lighting and Outlets:** Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets or circuits.

|  |   |
|--|---|
|  | <p><b>⚠ CAUTION</b><br/>Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting, or operating equipment.</p> |
|--|---|



# SECTION 4: ASSEMBLY



## Order of Assembly

We have organized the assembly process of the Model G1012 into steps listed below. Please follow them in sequence. The inventory photos and lists, hardware recognition chart, parts list and exploded diagram have been provided to make assembly as easy as possible.

1. Stand
2. Motor
3. Mounting Unit to Stand
4. Wiring
5. Pulley Alignment
6. Table
7. Fence Assembly
8. Total Unit Check

## NOTICE

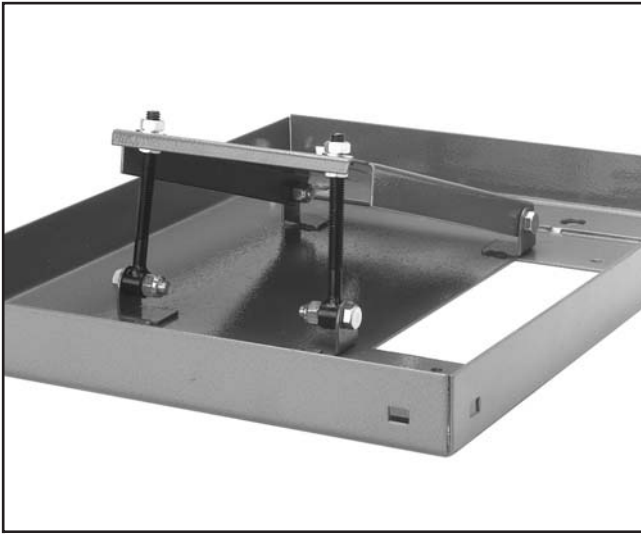
**TOOLS REQUIRED:** In addition to the tools provided with your bandsaw, you will need a metric set of wrenches, large and medium flat-tipped screwdrivers, a Phillips® screwdriver, and a 6" or 8" adjustable wrench.



## Stand

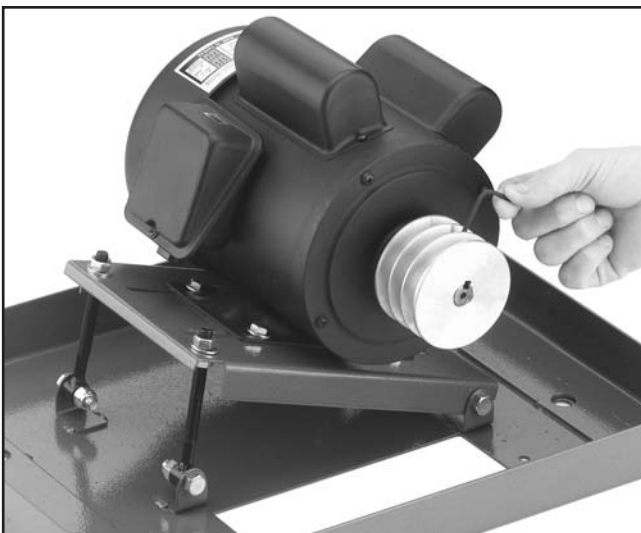
To begin the stand assembly, locate all the stand parts so they are within easy reach.

1. Flip the stand top upside down. Install the two adjustment bolts on the stand top by placing the  $\frac{3}{8}$ "-16 x  $1\frac{1}{4}$ " carriage bolts through the mounts on the stand top and then the through eyes of the adjustment bolts. Secure with  $\frac{3}{8}$ " washers and hex nuts, but do not completely tighten.
2. Using (2)  $\frac{3}{8}$ "-16 x  $\frac{3}{4}$ " carriage bolts, washers, and hex nuts; attach the motor bracket to the mounts on the stand top without tightening.
3. Place a  $\frac{3}{8}$ "-16 hex nut and washer on each adjustment bolt, then rotate the motor bracket over the adjustment bolts, and secure with another  $\frac{3}{8}$ "-16 hex nut and washer so your assembly looks like **Figure 5**. Again, do not completely tighten at this time.



**Figure 5.** Motor bracket attached to stand top.

4. Mount the motor onto the motor bracket. Secure with (4)  $\frac{5}{16}$ " -18 x  $\frac{3}{4}$ " hex head bolts, washers and nuts. Hand-tighten for now.
5. Place the smallest key in the groove on the motor shaft. Line up the key on the shaft with the pulley keyway. Slide the motor pulley (the small triple-grooved pulley) onto the motor shaft. Insert one of the small  $\frac{1}{4}$ "-20 x  $\frac{1}{4}$ " setscrews in the bottom of the middle pulley groove and tighten with the included 3mm hex wrench as shown in **Figure 6**.



**Figure 6.** Securing motor pulley to motor shaft.

6. Attach the four legs to the top of the stand using the  $\frac{5}{16}$ "-18 x  $\frac{1}{2}$ " carriage bolts, washers and nuts provided. Do not tighten down bolts completely at this time.

7. Attach the two horizontal braces to the legs and secure with the  $\frac{5}{16}$ "-18 x  $\frac{1}{2}$ " carriage bolts, washers and nuts provided. Attach one of the stand sides on the opposite side of the pulley slot in the stand top. Your assembly should now look like **Figure 7**.



**Figure 7.** Legs, braces, and one stand side attached to stand

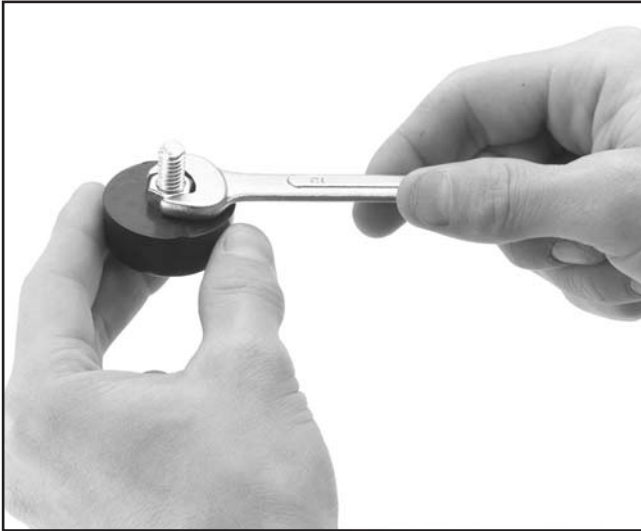
## NOTICE

As an option, you may attach the other stand side to the stand at this time. Performing this step now will ease assembly of this part, but it will limit your access to the motor pulley when installing V-belts.



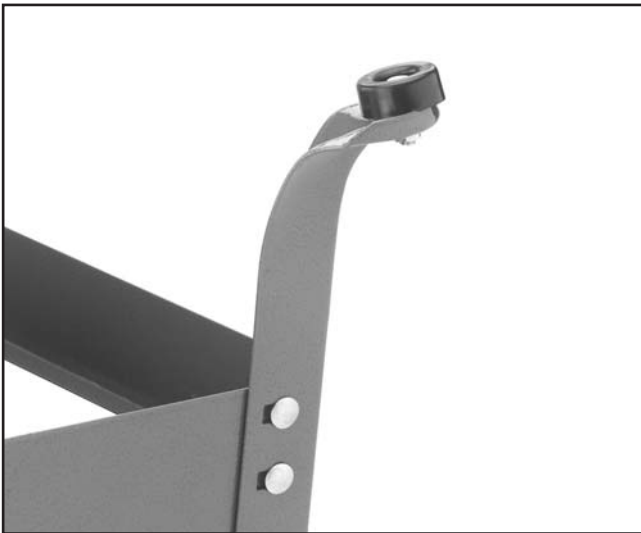
**Figure 8.** Legs, braces, and both stand sides assembled as an option.

8. Prepare the four rubber feet by placing the  $\frac{5}{16}$ "-18 x 1" bolts through the rubber feet and tightening the  $\frac{5}{16}$ "-18 hex nuts as shown in **Figure 9**.



**Figure 9.** Preparing rubber feet for installation.

9. Install each rubber foot on the bottom of each leg. Thread on another  $\frac{5}{16}$ "-18 hex nut to tighten the rubber foot to the leg as shown in **Figure 10**.



**Figure 10.** Rubber foot installed.

10. Flip the stand upright and adjust it back and forth so it is level and symmetrical on the legs. Now, tighten all of the stand bolts (except the last stand side if you left it off) to secure the bandsaw unit in place.

At this point, place the bandsaw on the stand. Ensure that the bandsaw pulley shaft is positioned over the rectangular hole in the stand.

When the bandsaw is positioned on the stand, fasten it (as shown in **Figure 11**) with the (4)  $\frac{1}{2}$ "-12 x 1 $\frac{1}{2}$ " hex head bolts, washers and nuts provided. Tighten securely.



**Figure 11.** Bandsaw unit mounted to stand.

## CAUTION

The Model G1012 can be awkward to handle without assistance. The bandsaw unit is also very unstable until it is permanently mounted to the stand. Failure to use caution during assembly could lead to serious personal injury.





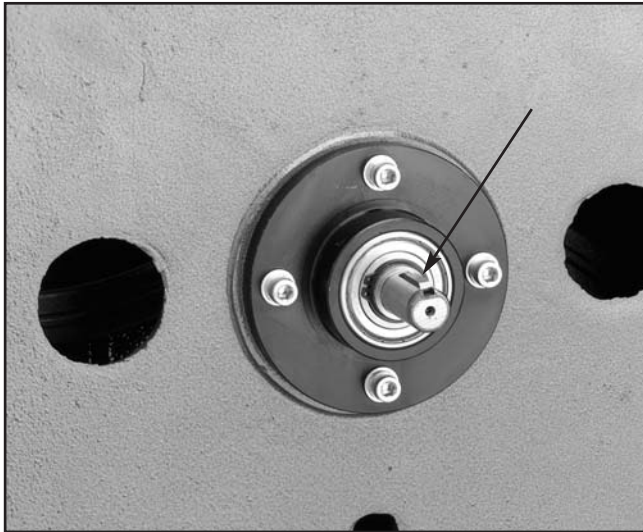
# Pulleys

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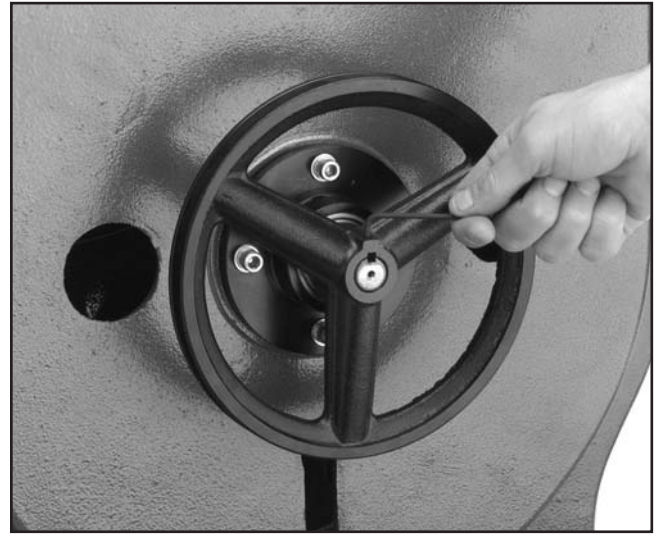
With the bandsaw unit mounted firmly onto the stand, the pulleys need to be installed next.

1. Locate the upper pulley from your loose parts. Make sure the key is in the upper pulley shaft keyway as shown in **Figure 12**.



**Figure 12.** Key in wheel pulley shaft.

2. The wheel pulley is shaped so that it must be installed with the curved side out (look at the side profile of the wheel pulley to determine this shape).
3. Align the the keyway in the pulley to the key on the shaft and insert the wheel pulley as far as it will go on the shaft. A few taps with a dead blow rubber hammer may be necessary to fit the wheel pulley all the way onto the shaft.
4. Insert one of the 1/4"-20 x 1/4" setscrews into the wheel pulley and tighten to the shaft as shown in **Figure 13**.



**Figure 13.** Securing wheel pulley to shaft.

5. Install the stepped pulley through the opening in the bandsaw unit, directly below the wheel pulley.
6. Thread one of the 5/8"-11 hex nuts onto the stepped pulley shaft, followed by a 5/8" washer. Place this assembly through the opening in the bandsaw unit and secure with another washer and hex nut from inside the bandsaw unit. Leave the last hex nut loose enough that you can still move the stepped pulley for further adjustments.



# V-Belts

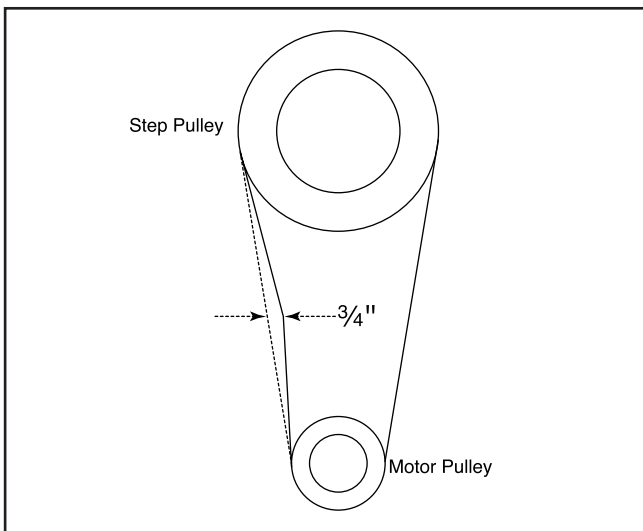
In order to ensure proper power transmission from motor to band wheels, the pulleys should be aligned and the belts should have proper tension. To begin pulley and belt assembly:

1. Place the A32 belt in the wheel pulley groove and the last groove in the stepped pulley as shown in **Figure 14**.



**Figure 14.** Stepped pulley installed with wheel pulley V-belt in place.

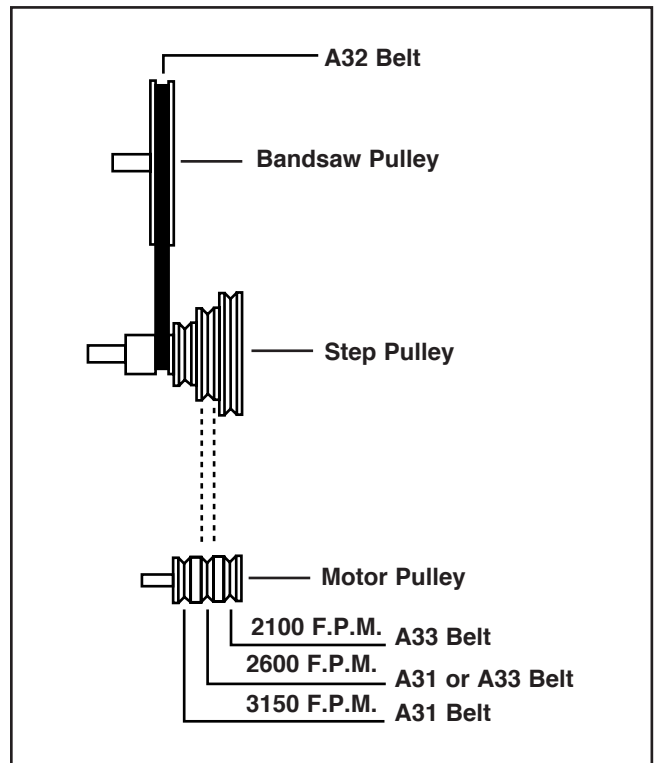
2. Tension the belt by pushing the stepped pulley down in the shaft slot. The belt deflection should be approximately  $\frac{3}{4}$ " when you push on the center of the belt (similar to **Figure 15**) with your index finger.



**Figure 15.** Pulley deflection w/moderate pressure.

3. Adjust the motor back and forth until the V-grooves line up with the V-grooves on the three-step pulley.
4. Slip either the 31" or 33" belt over the motor pulley and the step pulley, depending on the desired speed. For general woodworking, we recommend setting the lower belt for the fastest rate of speed. See **Figure 16** for speeds.

*You may have to back off the nuts on the motor adjustment bolts to allow enough motor swing to attach the belt.*



**Figure 16.** Pulley speed chart.

5. To align pulleys, there is a variety of adjustment. For example:
  - A. The band wheel pulley can be slid along the shaft.
  - B. The three-step pulley can be adjusted away from the base by doubling up a washer.
  - C. The motor pulley can be turned around and repositioned on the motor shaft.

Remember, the motor should remain level after any adjustments.

6. To tighten the belt from the stepped pulley to the motor, loosen the nuts on each motor adjustment bolt and lower the motor into position. The weight of the motor is sufficient for the amount of tension required. Tighten the nuts against the motor plate, so your assembly looks similar to **Figure 17**.



**Figure 17.** V-belts mounted on pulleys.



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## Belt Guard

1. When all belts are installed, aligned, and tightened, fasten the last stand side to the stand legs. (If this has already been done, skip this step.)
2. Place the belt cover over the pulleys on the bandsaw unit and secure with the (2)  $\frac{1}{4}$ "-20 x  $\frac{1}{2}$ " hex bolts, (4)  $\frac{1}{4}$ " washers, and (2)  $\frac{1}{4}$ "-20 hex nuts. Your assembly should now look similar to **Figure 18**.



**Figure 18.** Belt cover mounted to stand.

### **WARNING**

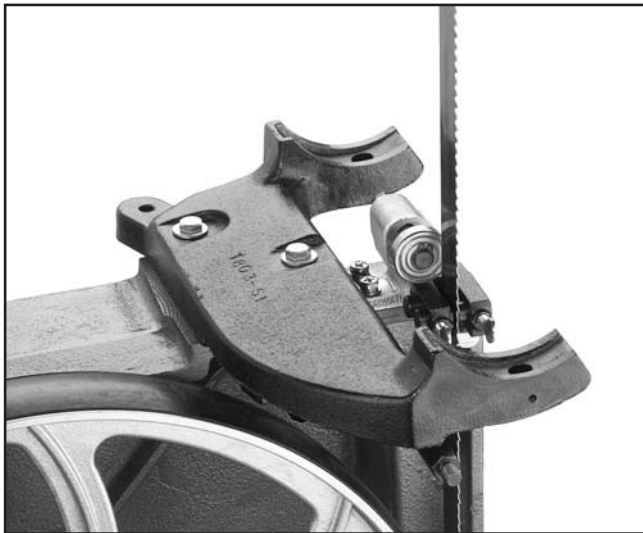
**DO NOT** operate bandsaw with cover removed or serious personal injury may occur!



# Table

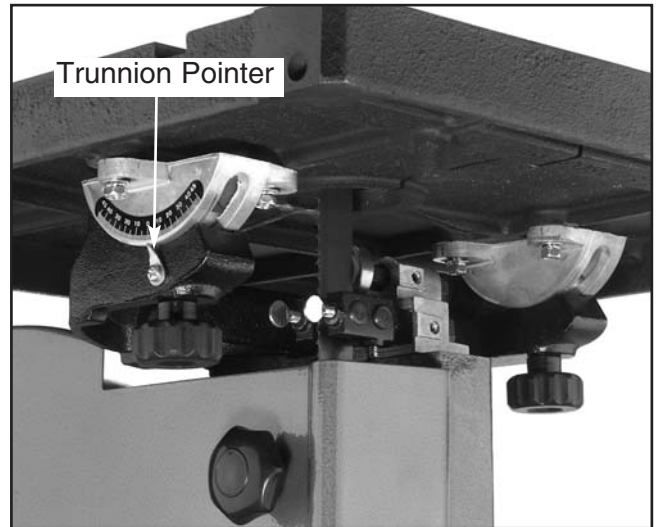
## To mount the table to the bandsaw unit:

1. Locate the trunnion casting from your loose parts. The mounting bolts are already in the table saw unit, near the lower blade guides. Remove these bolts and their washers.
2. Line up the holes on the trunnion casting with the roll pins that are in the bandsaw unit. Tap the trunnion casting down onto the bandsaw unit. Secure with the hex bolts and washers as shown in **Figure 19**.



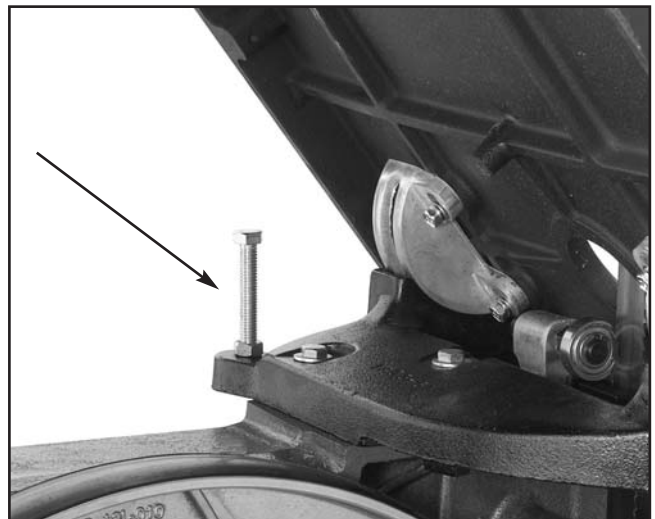
**Figure 19.** Trunnion casting mounted to bandsaw unit.

3. Using the table slot for access, remove the table pin and guide the bandsaw table around the blade so the blade is centered in the table. Rotate the table 90° and carefully place the table on the trunnions, so that the threaded studs go through the holes in the trunnions.
4. Using the two plastic knobs from your hardware bags, secure the table to the trunnions as shown in **Figure 20**.



**Figure 20.** Table mounted on trunnion casting.

5. The Model G1012 includes a positive stop bolt for quick table adjustments. Locate the  $\frac{3}{8}$ "-16 x 3" hex bolt from your hardware bag and thread it into the trunnion casting as shown in **Figure 21**. Use a  $\frac{3}{8}$ "-16 hex nut from the hardware bag to lock the bolt in place.



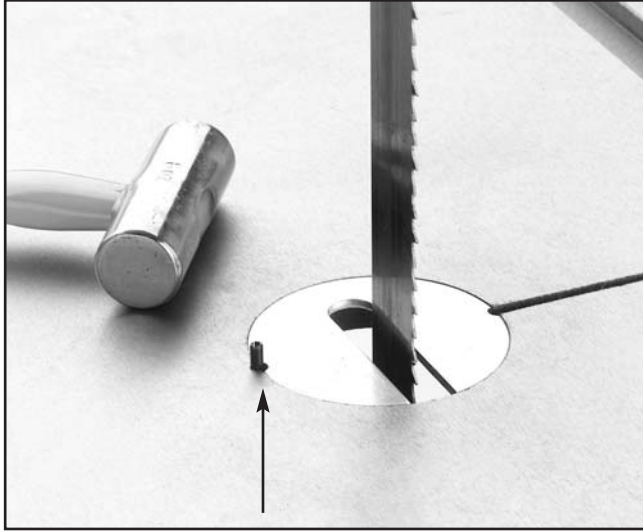
**Figure 21.** Positive stop location/installation.

6. Fit the tapered table pin in the opening of the access slot.
7. After verifying that the positive stop holds the table 90° to the blade, set the trunnion pointer to 0° on the trunnion gauge.

## CAUTION

Always keep the tapered table pin in place when operating the bandsaw.

7. Install the table insert in the center of the table. Rotate the table insert so the notch in the insert lines up with the notch in the table to form a small hole. Locate the roll pin from your hardware bags and tap it into this small hole as shown in **Figure 22**.



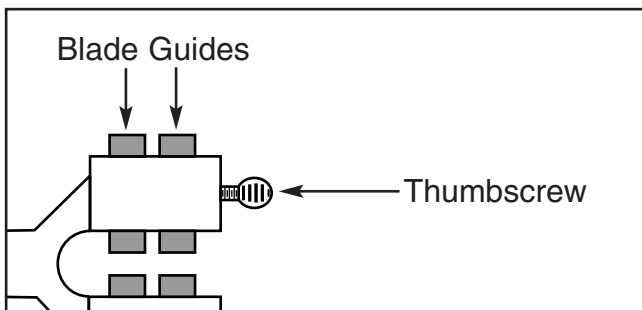
**Figure 22.** Inserting roll pin in table.



## Blade Guides

### To install the upper and lower blade guides:

1. Locate the eight blade guides from your hardware bags. Insert the blade guides in the holes that face the bandsaw blade.
2. Secure the blade guides by screwing the thumbscrews into the threaded holes that intersect the blade guides as shown in **Figure 23**.



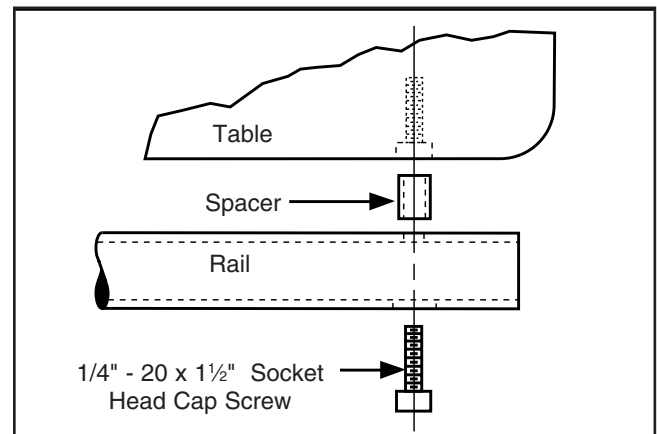
**Figure 23.** Blade guide assembly.



## Fence

The last item to install is the rip fence. Notice on the front and back edge of the table there are (4)  $\frac{1}{4}$ " threaded holes. These holes accept the cap screws that secure the fence rails to the table. This assembly is illustrated in **Figure 24**.

1. Attach the rear fence rail to the table with the (4)  $\frac{1}{2}$ " - 20 x 2" cap screws and spacers provided.
2. If you wish to mount the fence to the left of the blade, the fence must be mounted to the front rail before it is attached to the table. Otherwise, you will need to remove the blade to slide the fence over.
3. Secure the mounting bolts and ensure that the fence slides easily on the rails. Apply a shot of light oil or silicone spray to each rail for better movement. To remove the fence from the table, reverse **steps 1-3**.



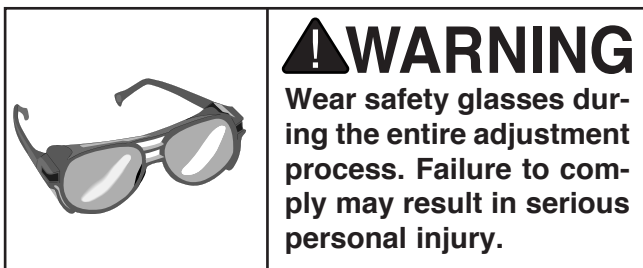
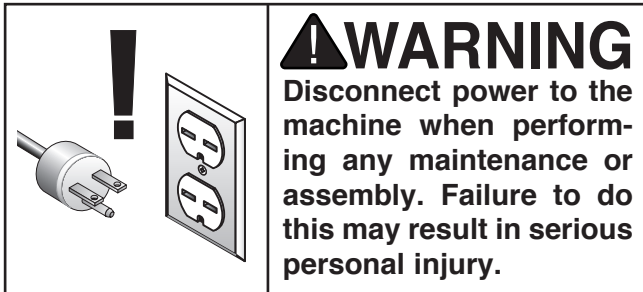
**Figure 24.** Attachment of fence rail to the table.



## **!**WARNING

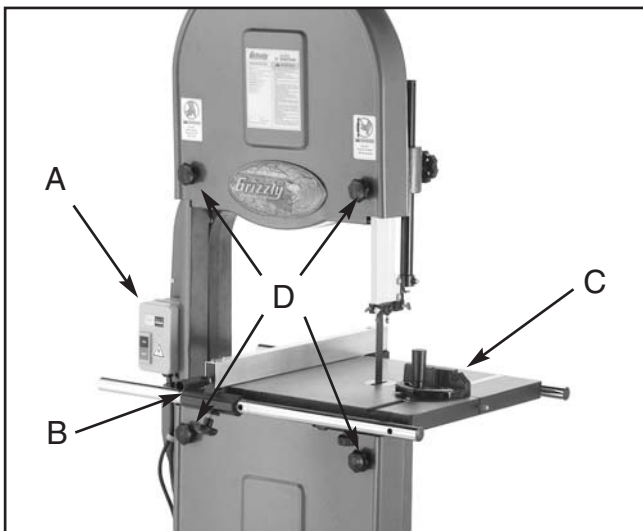
This concludes assembly of the bandsaw. Please **DO NOT** operate this saw until you have read and have followed the safety information, adjustment and operation sections in this manual. Operation without complete knowledge of this machine could lead to serious operator injury or damage to the machine or workshop.

# SECTION 5: ADJUSTMENTS



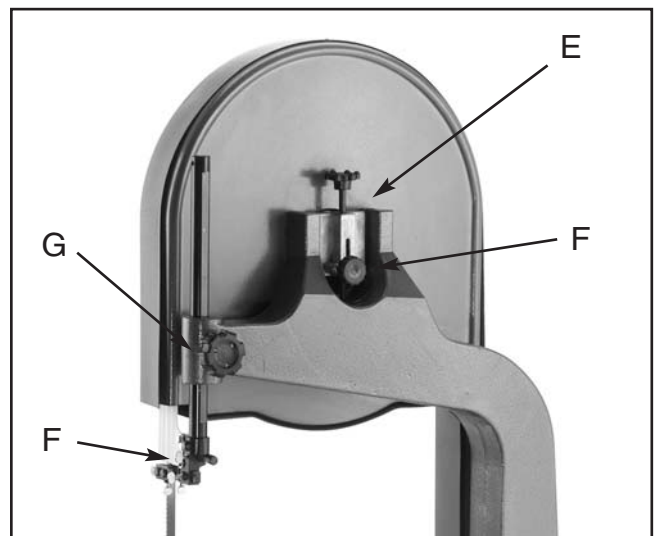
## Controls

Review the bandsaw controls and locations shown in **Figures 25 & 26**. The following callouts describe each control function.



**Figure 25.** Front controls.

- A. SWITCH — Turns the bandsaw ON/ OFF.
- B. FENCE LOCK — Locks/unlocks fence clamp for adjustments.
- C. MITER GAUGE — Primarily used for making crosscuts.
- D. WHEEL COVER KNOBS — These knobs are used to attach/detach the wheel covers.



**Figure 26.** Rear controls.

- E. TENSION KNOB & GAUGE — Knob loosens and tightens the blade tension and is measured by the tension gauge.
- F. TRACKING KNOB — Tilts the upper wheel forward/backward.
- G. BLADE GUIDE HEIGHT KNOB — Loosens blade guide post to raise/lower blade guides and blade guard.
- H. BLADE GUIDE ASSEMBLY — Houses the blade guides and rear support bearing.



# Blade Tracking

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There are two ways to track a bandsaw blade: **Center Tracking** and **Coplanar Tracking**. Center Tracking is the fastest and easiest, but not the most precise.

## Center Tracking:

1. **Disconnect the bandsaw from the power source!**
2. Adjust the upper and lower guide blocks and support bearings away from the blade. Remove the upper wheel cover.
3. Adjust blade tension to how it will be used during operation.
4. Loosen the tracking control lock nut. Turn the tracking control knob clockwise/counter-clockwise while turning the upper wheel by hand until the blade stays centered on the wheel.
5. Spin the upper wheel by hand at least three times to ensure that the blade stays centered. If the blade does not stay centered, re-adjust as necessary.
6. Tighten the tracking control lock nut and replace the upper wheel cover.

For the best performance from your saw, regularly maintain proper tracking of the blade.

For **Coplanar Tracking**, see the “Wheel Alignment” instructions.

## CAUTION

Be careful when turning the band wheels by hand. The aluminum spokes may have sharp edges and the blade teeth may extend beyond the edge of the wheel.



# Blade Tension

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## To adjust the tension:

1. Loosen the upper and lower guide blocks and raise the upper guide block as high as it will go.
3. With moderate tension already on the blade, turn the bandsaw ON.
4. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.
5. Now, slowly increase the tension until the blade stops fluttering. Tighten the tension one more quarter of a turn.
6. Look at what the tension gauge reads and use that as a guide for tensioning your blade in the future.

If the tension seems correct, turn the bandsaw OFF and make the other adjustments, and test run. If the blade does not cut properly, the tension may be incorrect. Re-adjust the tension. New blades often stretch with use. However, removing the tension from the blade when not in use will reduce stretching and extend your blade life.

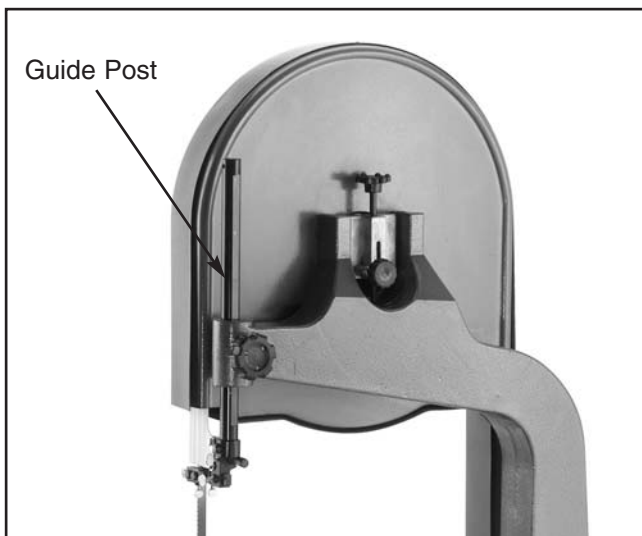


# Guide Post

The guide post (shown in **Figure 30**) is adjustable so the guide blocks will stay aligned with the blade when the guide post is raised or lowered.

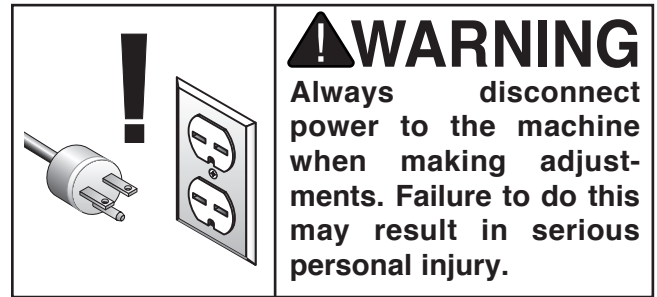
**To adjust guide assembly alignment on guide post:**

1. Adjust blade tension and tracking.
2. Loosen the guide blocks in the upper and lower guide assemblies.



**Figure 27.** Tension and guide post controls.

3. Note where the blade is in the guide block holder. It should be roughly centered. If it is not centered, loosen the hex bolt that secures the blade guide assembly to the guide post.
4. Rotate the guide assembly so the blade is centered between each side of the guide block holders.
5. Tighten the hex nut that secures the blade guide assembly to the guide post.



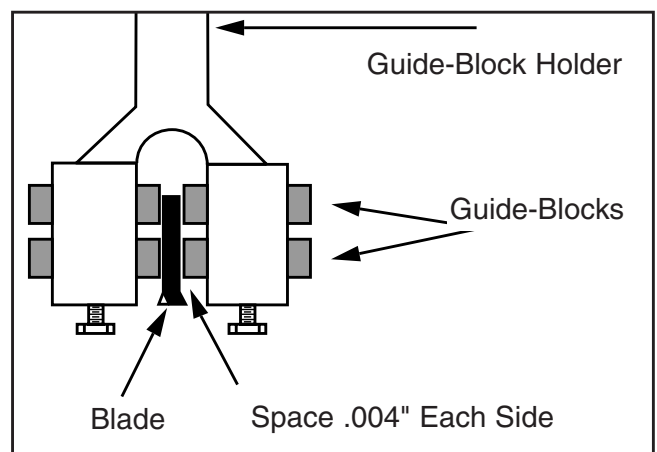
## Blade Guides

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide-blocks must be re-adjusted. Always loosen the thumbscrews/setscrews and knobs and adjust the assemblies away before installing a new blade or making blade adjustments. After blade tension and tracking are set correctly, re-adjust the upper and lower support bearings and guide-block assemblies into position.

### UPPER BLADE GUIDE ASSEMBLIES

The guide-blocks support the blade from both sides. The steel guide-blocks should be set .004" from the blade as illustrated in **Figure 27**. The guide-block holder should be adjusted so the front blocks are  $\frac{1}{16}$ " behind the saw gullets.

**To set the guide-blocks within the guide-block holder:**



**Figure 28.** Proper guide block adjustment.

1. Loosen the setscrews locking the guide-blocks in the guide-block holder.

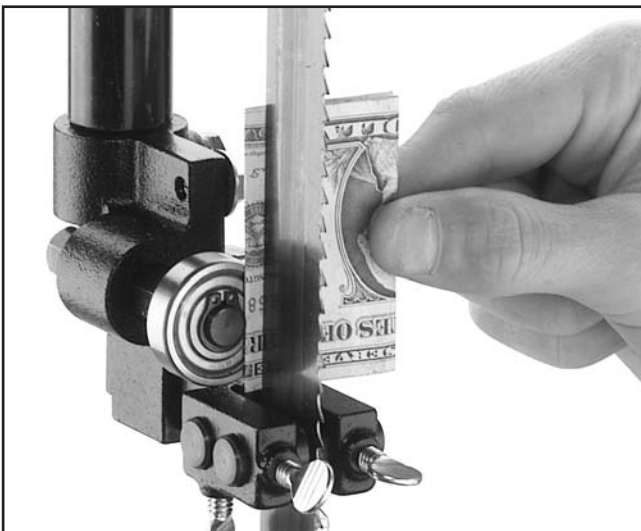


2. Clearance between the blade and the guide-blocks should be .004" (similar to the thickness of a dollar bill). For an easy gauge, fold a dollar bill in half and place each half on each side of the blade as in **Figure 28**.
3. Adjust the guide blocks and lock into position by tightening the thumbscrews. Remove the dollar.



**Figure 29.** Single dollar thickness on each side of the blade.

The support bearings back-up the blade during the sawing operation. To adjust the upper support bearing, loosen the shaft setscrew. The upper blade support bearing should be adjusted to within .016" (four thicknesses of a dollar bill) behind the blade as shown in **Figure 29**. Retighten the shaft setscrew.



**Figure 30.** Dollar folded twice for support bearing adjustment.

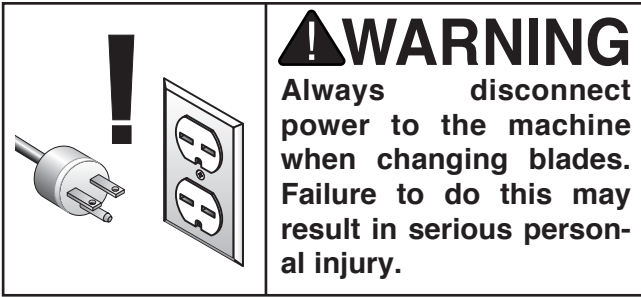
## LOWER BLADE GUIDE ASSEMBLIES

The lower blade guide assemblies should be adjusted to the same tolerances as the upper guide assemblies.

1. Adjust lower support bearing to within .016" from the rear of the blade.
2. Adjust lower guide-blocks to .004" from blade sides.
3. Adjust lower guide-block holder to within  $\frac{1}{16}$ " behind blade gullets.
4. Secure all adjustment knobs and screws.
5. Make sure the blade tracks true. Inspect for any blade deflection caused by incorrect positioning of the guide blocks. The support bearings should rotate only under load.



# Blade Changes



## To remove the blade:

1. Unplug the bandsaw!
2. Release tension on the blade by turning the tension control knob counter-clockwise.
3. Remove the table insert and the table pin. Adjust the upper and lower guide blocks away from the blade.
4. Put on leather gloves to protect your hands from the sharp teeth of the blade.
5. Open the upper and lower wheel covers and slide the blade off both wheels. Use caution — the blades are sharp!
6. Rotate the blade 90° so it will slide through the slot in the table.

## CAUTION

Wear gloves and safety goggles when handling blades. Coiled blades spring open as they are uncoiled and could cause deep punctures or lacerations.

When removing or installing wide blades, it may be convenient to completely remove the upper and lower guide blocks. Be sure to replace them before cutting. **To replace the blade:**

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table.

If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it rightside-out.

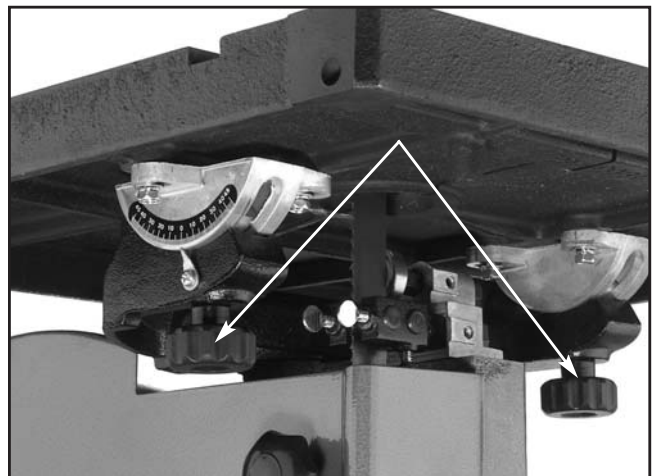
2. Slip the blade through the upper and lower guides, and mount it over the upper and lower wheels.
3. Apply tension, then check and adjust tracking.
4. Adjust the upper and lower guide blocks and the support bearings.
5. Close and tighten the wheel covers.
6. Replace the table insert and table pin, being sure not to use excessive force when inserting the table pin.



# Table Adjustments

The bandsaw table will tilt 5° left and 45° right from horizontal. There is an adjustable positive stop so the table can be reset perpendicular to the blade after tilting to the right. **To tilt the table:**

1. Loosen the two plastic knobs underneath the table as shown in **Figure 31**.
2. Position the table to the desired angle of tilt. Refer to the angle gauge on the front table trunnion for the tilting angle.
3. Retighten both plastic knobs.



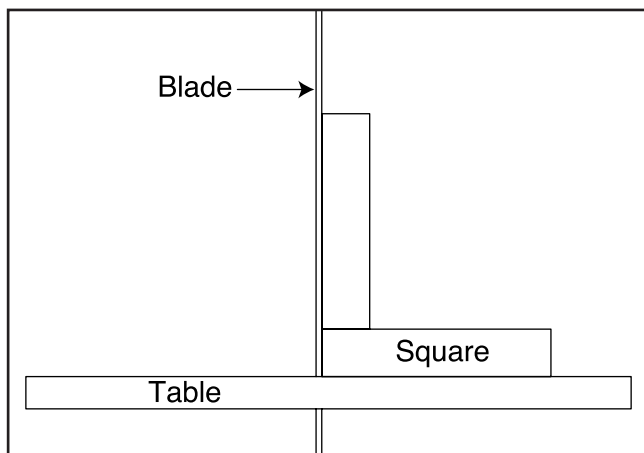
**Figure 31.** Plastic trunnion knobs.

# NOTICE

If setting table tilt to the left, it will be necessary to remove the positive stop.

To adjust the positive stop so the table will be 90° to the blade:

1. Loosen the two plastic knobs and check-nut that secure the positive stop adjusting bolt shown in **Figure 32**.
2. Raise the upper blade guide assembly and place a 6" machinist's square or try-square on the table next to the side of the blade. Adjust the positive stop adjusting bolt to raise or lower the table until the table is 90° to the blade.

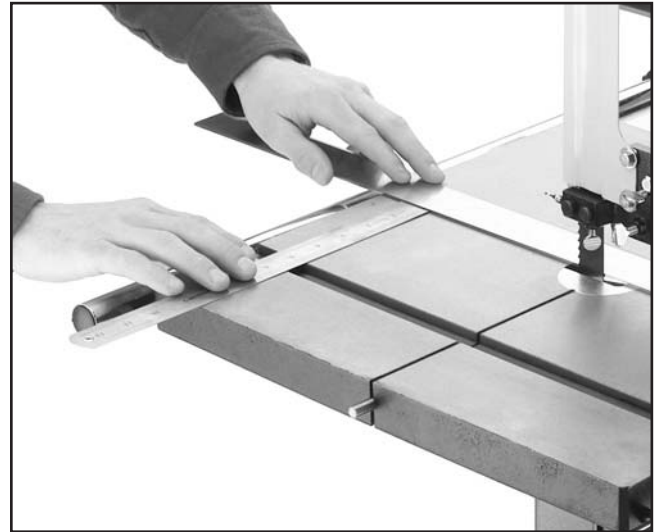


**Figure 32.** Squaring table to blade.

3. Secure the plastic knobs and lock the positive stop adjusting bolt by tightening the check-nut. Ensure that the bolt does not turn while tightening the check-nut.

To adjust the miter slot parallel to the band-saw blade:

1. Loosen the six trunnion bolts underneath the table.
2. Place a good straightedge along the blade. The straightedge should touch the front and the back of the blade. Use a fine ruler to gauge the distance between the blade and the miter slot as shown in **Figure 33**. The distance you measure should be the same at both the front and the back of the table.

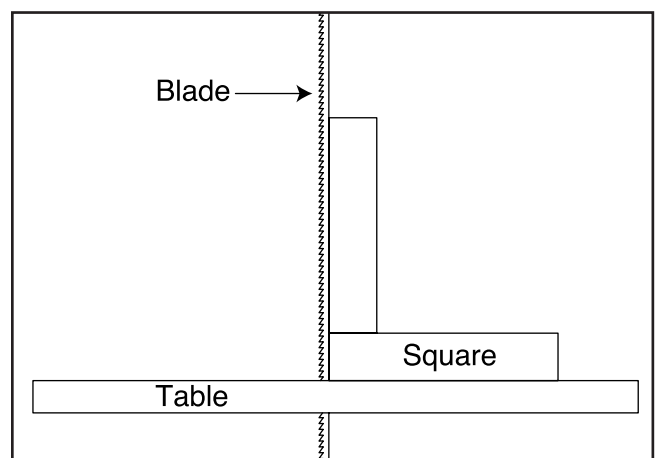


**Figure 33.** Squaring table to blade.

3. Adjust the table in the desired direction and secure in position by retightening the trunnion bolts.

The table should also be 90° to the back of the blade as shown in **Figure 34**. If you should find that the table is not perpendicular to the back of the blade, shim the table in the desired direction by placing washers between the table and the two trunnions.

Remove the trunnion bolts and add washers so the table tilts in the desired direction. Electrical washers are very thin and will allow fine adjustment.



**Figure 34.** Squaring table to blade back.



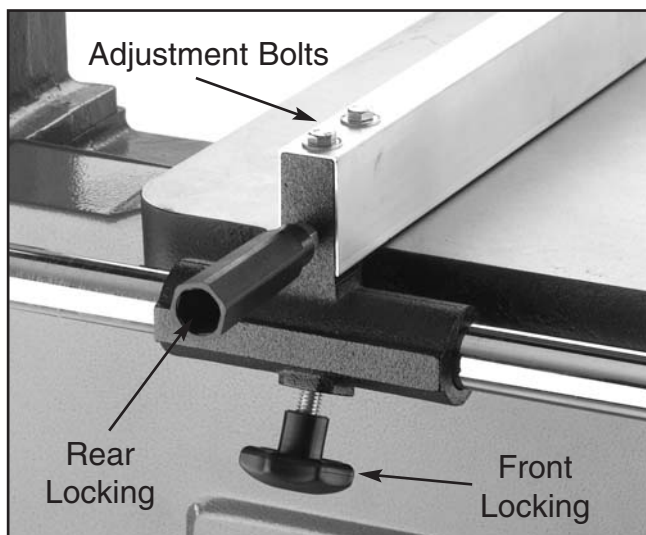
# Fence Adjustment

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Fence locking is controlled by turning the two handles on the front of the fence. The straight handle controls the locking clamp on the back rail and the star knob controls the locking clamp on the front rail. See **Figure 35** for control locations. Both of these knobs must be loosened when moving the fence.

When adjusting your fence to the desired cutting width, use a tape measure or a ruler to measure the distance from the fence to the blade. Always lock the front locking knob first.



**Figure 35.** Fence controls.

If your fence does not clamp square, the adjustment bolts shown in **Figure 35** can be loosened to allow you to slightly adjust the fence one way or another. When the fence is in the desired position, tighten the bolts to lock it in place.



# Blade Lead

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Most bandsaw blades will not appear to cut straight when using the fence or miter gauge. This is called “lead.” (See **Figure 36.**) Lead occurs (1) if the blade tension is incorrect, (2) if the teeth are dull on one side, or (3) if the teeth are set heavier on one side of the blade than the other.

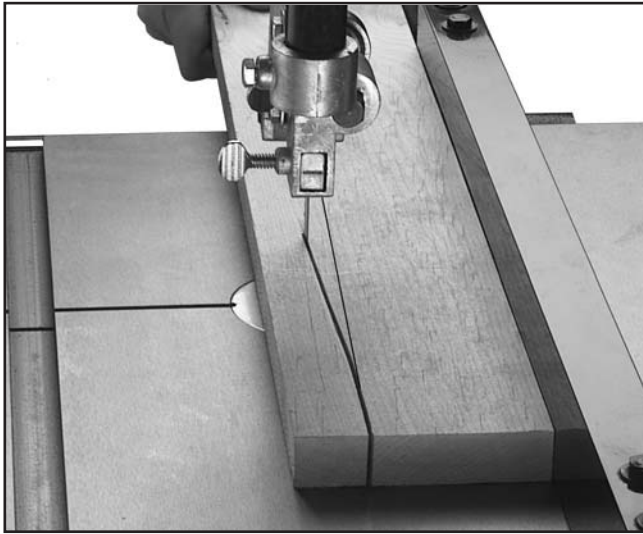
**If you notice that your blade is not cutting straight (i.e. leading) while using the fence or miter gauge:**

1. Check that the miter slot or fence is parallel to the blade line.
2. Check that you have proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by skewing the fence or adjusting the table.

**To skew your fence:**

1. Obtain a piece of scrap wood that is approximately  $\frac{3}{4}$ " thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.
2. Slide the fence out of the way and cut free-hand along the line. Stop at the halfway point. Turn the bandsaw off and *wait for the blade to stop*.
3. Clamp the board to the bandsaw table **without moving it**. Now slide the fence over to the board so it barely touches one end of the board.
4. Loosen the two skewing cap screws on top of the fence. **Figure 35.**
5. Skew the fence left or right so it is parallel to the edge of the scrap piece. You may need to readjust the fence locking mechanisms to gain maximum adjustment.
6. While maintaining the skew, tighten the cap screws.

# Wheel Alignment



**Figure 36.** Blade leading away from line of cut.

**To compensate for lead if making straight crosscuts using the miter gauge, you will need to shift the table. To do this:**

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge. Starting where the line begins, cut the board by pushing it through the blade with the miter gauge.
2. Loosen the table mounting bolts according to the instructions about “Table Adjustments” on **page 20**. Shift the table to compensate for the blade lead.
3. Repeat **steps 1 and 2** until the blade cuts straight when wood is pushed through with the miter gauge.

## NOTICE

**If the table is shifted, the fence will be affected since it is attached.**

## NOTICE

**Lead adjustments will change when new blades are mounted on the saw.**



Wheel alignment is one of the easiest ways to ensure you get optimal performance from your bandsaw. When wheels are aligned, or coplanar, the bandsaw is more likely to cut straight without wandering; and vibration, heat, and blade wear are considerably decreased because the blade is automatically balanced on the wheel. This is known as “**Coplanar Tracking.**”

**To verify if the the upper and lower wheels are coplanar:**

1. With the blade on and properly tensioned, hold a straightedge close to the center of both wheels. Make sure it fully extends across them as shown in **Figure 37**.



**Figure 37.** Checking wheel alignment with a straightedge.

2. A perfectly coplanar set of wheels will allow the straightedge to touch the top and bottom of the outside rims on each wheel. If this is the case with your wheels, then they are coplanar.
3. If your wheels are not coplanar, check them for adjustment by placing the straightedge on the lower wheel first – ensuring that it touches both the top and bottom rim – and adjust the tracking knob to see how the straightedge lines up with the upper wheel.

If the straightedge will not touch the top and bottom rim of the upper wheel evenly, first determine if the upper wheel needs to be moved forward or backward. You can only shim the wheels to come forward.

- If the front wheel is behind the straightedge then the front wheel can be shimmed.
- If the front wheel is comes forward from the plane of the lower wheel, the lower wheel needs to be shimmed forward, so the straightedge lines up even with both wheels.

**Shimming a wheel:**

1. Adjust the tracking knob so the top wheel is parallel with the bottom wheel. With the straightedge touching both points of the wheel that does not need to be adjusted, measure the distance away from the incorrect wheel with a fine ruler. See **Figure 38**. The distance you measured with the ruler is the distance the wheel must be corrected.

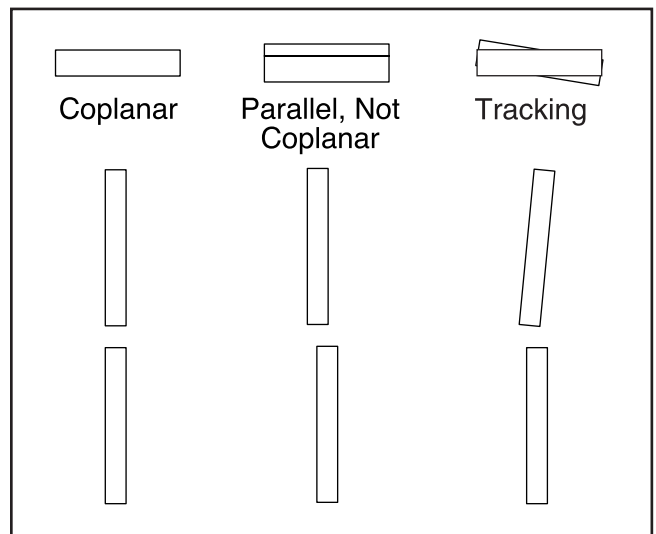


**Figure 38.** Measuring wheel difference.

2. Remove the blade from the saw, then remove the securing nut and the washers from the wheel that needs to be shimmed. Take the wheel off.
3. Electrical washers work well for shimming because they are offered in a wide range of thicknesses. Measure how many you will need and place them on the mounting shaft.

4. Replace the wheel, any remaining washers, and the securing nut. Tighten the blade as it will be used during operation before you check the wheels for being coplanar. Often the wheels may be coplanar with the blade loose, then be pulled out of alignment when it is tightened.
5. The first time you get the wheels coplanar, place a mark on each wheel where you held the straightedge. This assures repeated accuracy every time you adjust your wheels.

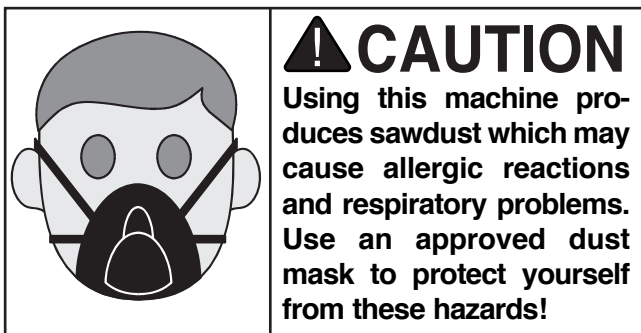
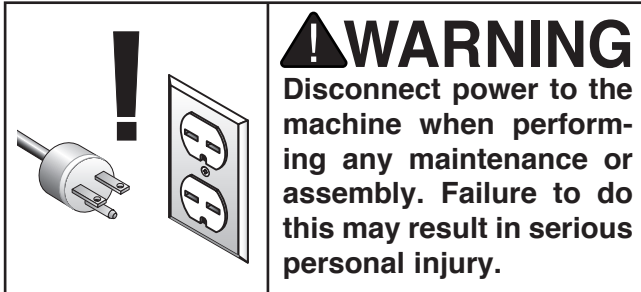
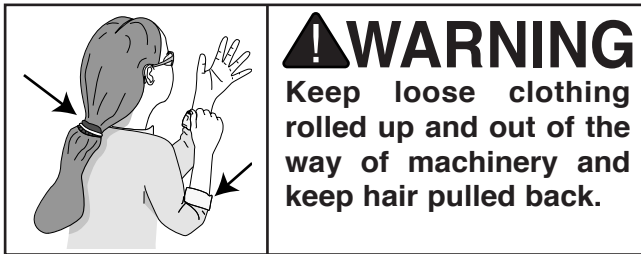
When wheels are properly coplanar, the blade may not be centered on the crown of the wheel, but it will be balanced. See **Figure 39** to better understand coplanarity.



**Figure 39.** Coplanar diagram.



# SECTION 6: OPERATIONS



## NOTICE

The following section was designed to give instructions on the basic operations of this bandsaw. However, it is in no way comprehensive of every bandsaw application. There are many different jigs that can be built to increase safety, accuracy, and types of cuts. **WE STRONGLY RECOMMEND** that you read books, trade magazines, or get formal training to maximize the potential of your machine.

## Test Run

Once the assembly is complete and the adjustments are done to your satisfaction, you are ready to test the machine.

Turn on the power supply at the main panel. Pull the paddle switch up to start the bandsaw. Make sure that your hand is poised over the switch in case there is a problem. The bandsaw should run smoothly with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further.

If you cannot easily locate the source of an unusual noise or vibration, feel free to contact our service department for help.



## Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing many different cutting functions including, but not limited to:

### STRAIGHT CUTS

- Miters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

### IRREGULAR CUTS

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

Although you can perform many types of straight cuts such as angling and mitering on the bandsaw, they will not be as precise as on a table saw. Also, since the blade is flexible, the resulting cut is somewhat rougher than one performed on a table saw. However, just as a table saw is suited to precision straight cuts and miters, the bandsaw excels when resawing and when cutting irregular shapes. A properly adjusted and tuned up bandsaw is also safer to operate than most other saws and is capable of performing many sawing functions with ease and accuracy.

A common fault when using a bandsaw is blaming the saw for not performing up to expectations. Many factors contribute to the performance of a bandsaw. Using the wrong kind of blade for the job or using a poor quality blade will result in unsatisfactory performance. Misuse of the saw or using incorrect sawing techniques can be unsafe as well as result in frustration and poor cuts. Remember, the blade does the cutting with the operator's guidance. Replace and clean blades as necessary and make adjustments periodically to keep the saw always running in top condition.

## NOTICE

**Set the top guide assembly so it is just above the top of the work at all times.**

Do not force the material against the blade, use light and even pressure. Light contact with the blade will permit easier line following and prevent undue friction, heat and work-hardening along the back edge of the blade.

Avoid trying to turn sharp corners because this will twist the blade. Remember, you must saw around corners.



# Blade Information

Selecting the right blade requires a combination of the various blade characteristics mentioned below, the type of material you plan to cut, and the type of cut you are going to perform.

## Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the wheel diameter. The Model G1012 is designed for blades that are 124" long. However, the tension adjustment will accommodate blades up to a maximum length of 125" and down to a minimum of approximately 123" in length.

## Blade Width

Measured from the the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection.

A narrow blade can cut tight curves (a small radius) but is not very good at cutting straight lines, because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines, but function poorly at cutting small curves because of their size.

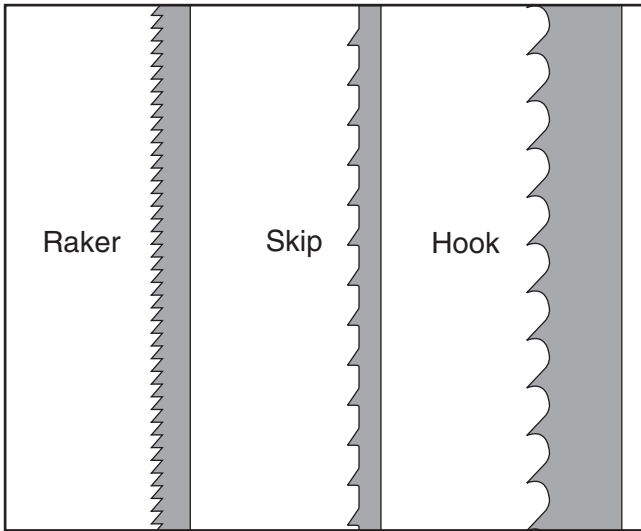
The Model G1012 functions best with  $\frac{1}{4}$ ",  $\frac{3}{8}$ ",  $\frac{1}{2}$ ", 1" and  $1\frac{1}{2}$ " widths. Refer to the current Grizzly catalog for prices and ordering information. Always pick the size of blade that best suits your application.

## Tooth Style

When selecting blades, another option to consider is the shape, gullet size and angle of the teeth — otherwise known as "Tooth Style."

**Figure 40** shows the three main categories of tooth style:





**Figure 40.** Raker, Skip & Hook tooth styles.

- **RAKER** — This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on Raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but at the same time do not cut fast and generate more heat while cutting.
- **SKIP** — This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.
- **HOOK** — The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

### Tooth Pitch

Usually measured as T.P.I. (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose

blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

### Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

### Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are: (1) faulty alignment and adjustment of the guides, (2) forcing or twisting a wide blade around a curve of short radius, (3) feeding too fast, (4) tooth dullness or absence of sufficient set, (5) excessive tension, (6) top blade guide assembly set too high above the work piece, (7) using a blade with a lumpy or improperly finished braze or weld and (8) continuously running the bandsaw when not in use.



# Ripping

Ripping is the process of cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece.

## To rip with the Model G1012:

1. Using a straightedge or other accurate guide, lightly pencil the workpiece along the desired path of cut.
2. Place the workpiece even along the fence and line up the penciled mark with the blade, having the blade kerf on the waste portion side of the workpiece. Lock the front and back of the fence in place.
3. Making sure all safety precautions have been taken, start the bandsaw. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 41** shows a typical ripping operation. When cutting narrow pieces, use a push stick to protect your fingers.



**Figure 41.** Ripping with a push stick.

## WARNING

**NEVER** place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may be pulled into the blade. **ALWAYS** use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!



# Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

## To crosscut with the Model G1012:

1. Using a straightedge or other accurate guide and lightly pencil the workpiece along the desired path of cut.
2. Move the fence out of the way. Place the workpiece evenly against the miter gauge.
3. Line up the penciled mark with the blade, having the blade kerf poised to cut through the waste portion of the workpiece.
4. After all safety precautions have been met, start the bandsaw. Slowly feed the workpiece into the blade and continue the cut until it is all the way through the workpiece. **Figure 42** shows a typical crosscutting operation.

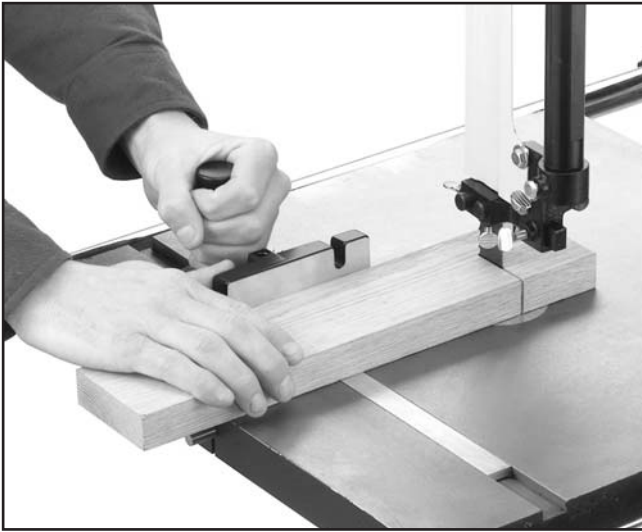


Figure 42. Crosscutting with miter gauge.

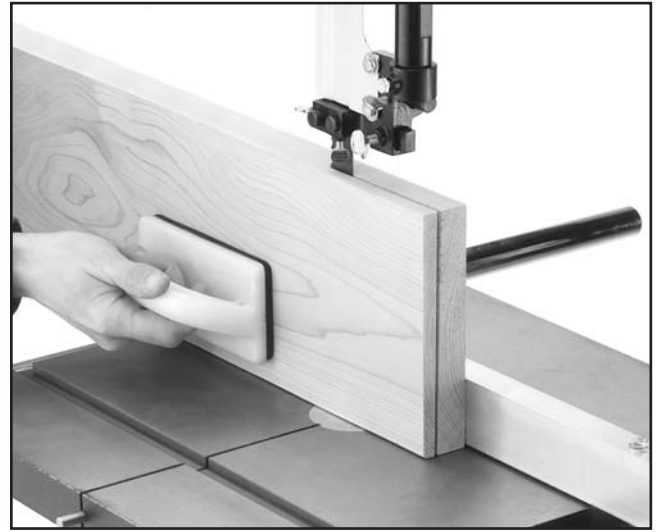


Figure 43. Resawing lumber.



## Resawing

Resawing (**Figure 42**) is the process of cutting a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw. Maximum cutting height for this bandsaw is 9½".

The Model G1012 18" Bandsaw is capable of resawing, provided the saw is set up properly. Use common sense when resawing. Attempting to resaw too wide or too dense of a board may put excessive strain on the blade and be dangerous.

The important consideration when resawing is blade selection. Generally, the wider blade, the better. In most applications, a hook or a skip tooth style will be desirable. Also, since most resawn lumber will be planed smooth, you should choose blades with fewer teeth-per-inch (from 3 to 6). While blades with fewer teeth-per-inch produce rougher cuts, these types of blades offer larger gullet capacities for clearing sawdust. They also produce less heat buildup and yield more horsepower per tooth.

1. The bandsaw must be adjusted correctly. See **Section 5: Adjustments**.
2. The table must be square to the blade.
3. Use the widest blade available. The blade must also be in good condition.
4. Use a fence to guide the work.
5. Draw a reference line on the edge of the board.
6. Support the ends of the board if necessary.
7. Feed the workpiece slowly and evenly.



# Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without being twisted. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use either a narrower blade or a blade with more T.P.I. A blade with more T.P.I. can cut relatively tighter radii, though the cut is usually rougher than cuts produced by a blade with a medium amount of T.P.I.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier, if needed.

## NOTICE

The table below lists blade widths and corresponding minimum radii each blade will cut.

| Width        | Radius |
|--------------|--------|
| 3/8" .....   | 1 1/2" |
| 1/2" .....   | 2 1/2" |
| 3/4" .....   | 5 1/2" |
| 1" .....     | 6"     |
| 1 1/2" ..... | 8"     |



## Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

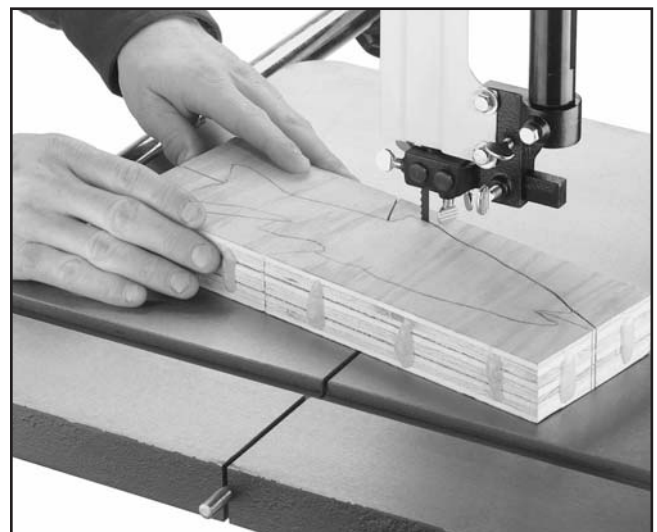
Before making stacked cuts, it is essential to ensure that both the table and the blade are properly adjusted to 90°. Otherwise, any error will be compounded with each piece cut from the top to the bottom of the stack.

### To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as does brad nails through the waste portion. (Be careful not to cut into the brads!)
3. On the face of the top piece, lay out the shape you intend to cut.
4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade kerf to bind.
5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line as shown in **Figure 44**.

## CAUTION

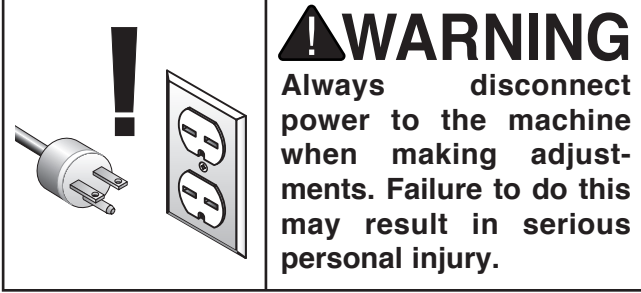
Cutting into brad nails that are used to secure the multiple pieces can cause the blade to brake and may cause an injury to the operator. Be extremely careful of where you are cutting when performing this operation.



**Figure 44.** Cutting multiple pieces at once.



# SECTION 7: MAINTENANCE



## V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension. The belts should be checked for cracks, fraying and wear. Belt tension should be checked at least every 3 months — more often if the bandsaw is used daily.

The V-belt is accessed via the bottom cover:

1. Push the center of the V-belt.
2. Note the amount of deflection. Deflection should be approximately  $\frac{3}{4}$ ". See "V-Belt Adjustment" instructions to adjust.



## Miscellaneous

Always be aware of the condition of your bandsaw. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts
- Worn switch
- Worn or damaged blade
- Worn or damaged support bearings or guide bearings



## Table

The table and other non-painted surfaces on the Model G1012 should be protected against rust and pitting. Wiping the saw clean after every use ensures that wood dust is not allowed to trap moisture against bare metal surfaces.

The table can be kept rust-free with regular applications of products like Boeshield® T-9. For long term storage you may want to consider products like Kleen Bore's Rust Guardit™. See the current Grizzly catalog for more on these products.



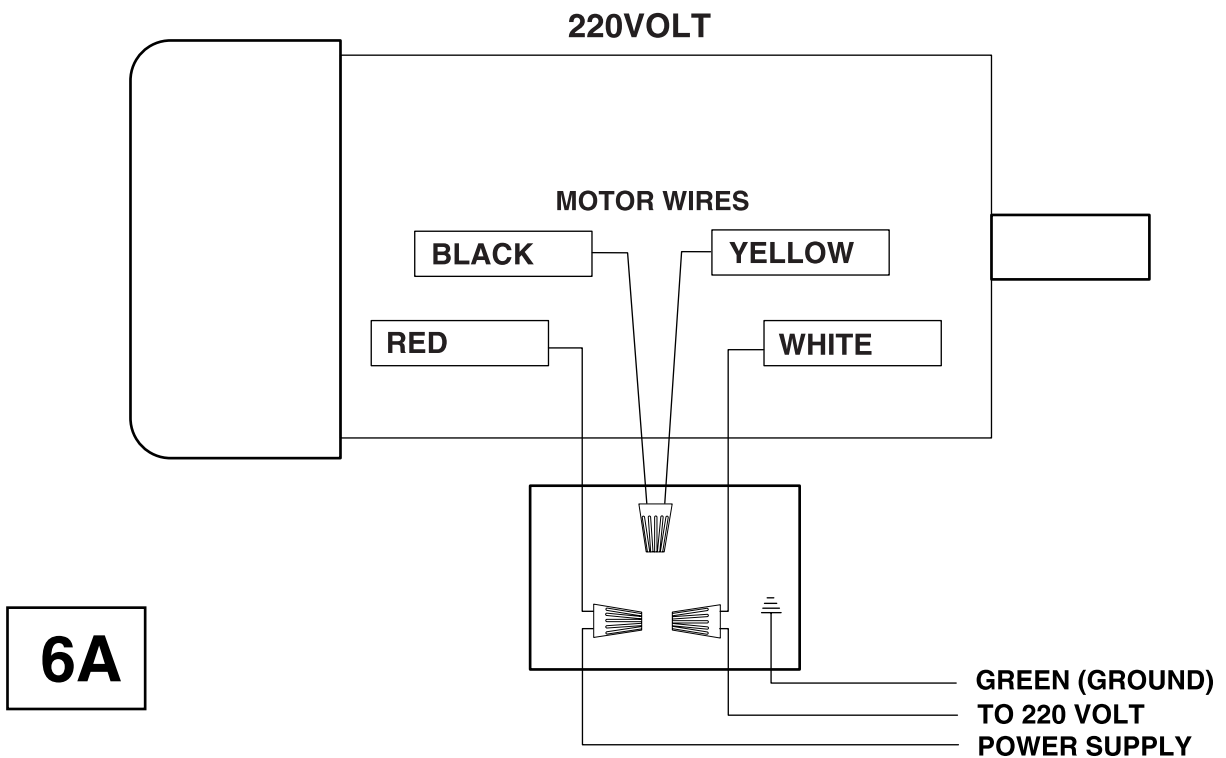
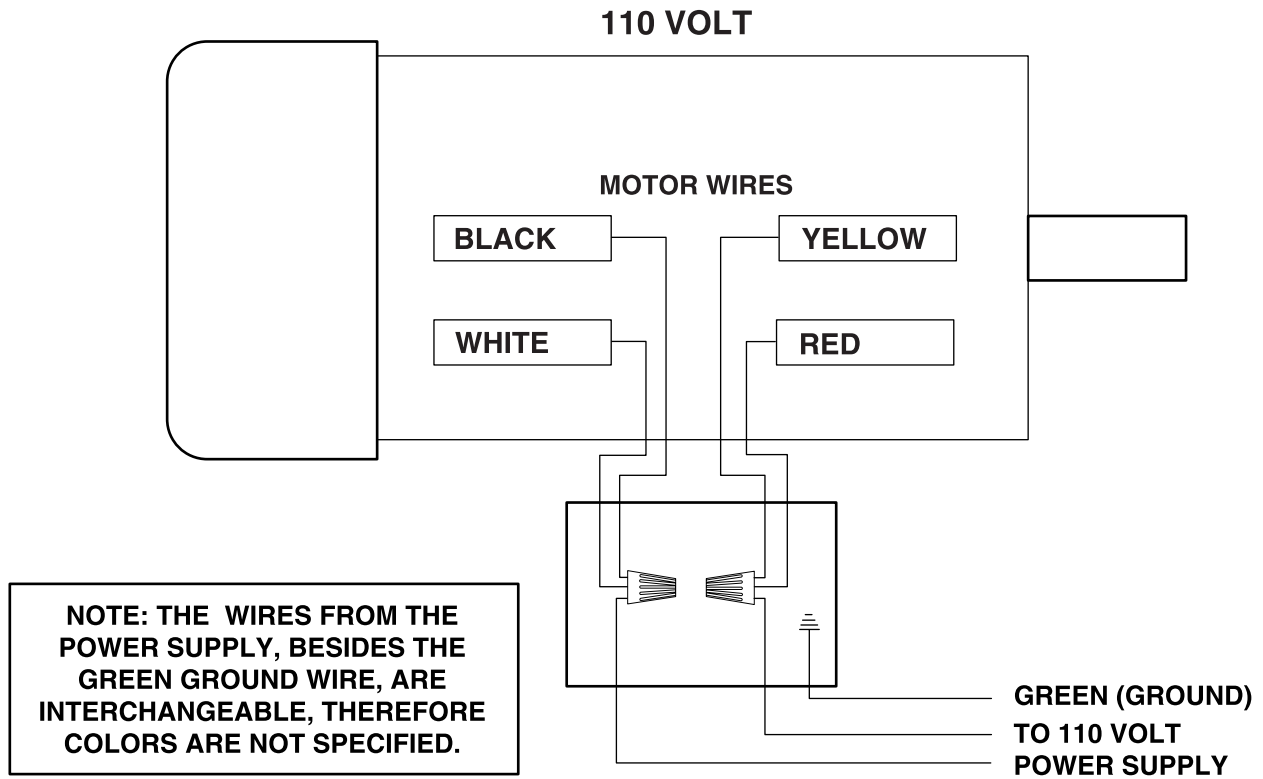
## Lubrication

Sealed and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or bearing supply store.

As for other items on this machine, such as adjustment controls, an occasional "shot" of light oil is just about all that is necessary. Before applying, however, wipe off any sawdust with a clean cloth, towel or dry paint brush, and spray on the lubricant. Ensure that oil does not get on the pulleys or V-belt because it could cause belt deterioration and slipping.



# WIRE DIAGRAM



# SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your Model G1012 18" Bandsaw.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the **General Information** section. The specifications, drawings, and photographs illustrated in this manual represent the Model G1012 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly.

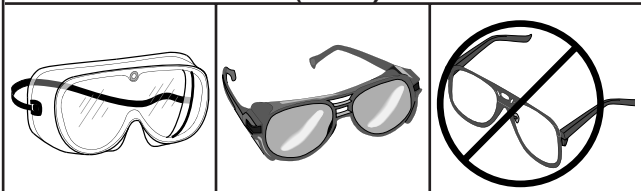
We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered as *they apply to your specific situation*.

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to your machine, or if you need general assistance or replacement parts, please contact the Service Department listed in the **General Information** section.

Additional information sources are necessary to realize the full potential of your machine. Trade journals, woodworking magazines, and your local library are good places to start.

## WARNING

Operating this equipment has the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).



## WARNING

Like all power tools, there is danger associated with the Model G1012 18" Bandsaw. Use the tool with respect and caution to lessen the possibility of mechanical damage or operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## WARNING

The Model G1012 was specifically designed for wood cutting operations. **DO NOT MODIFY AND/OR USE THIS BANDSAW FOR ANY OTHER PURPOSE.** Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, **DO NOT** use it until all your questions are answered. Serious personal injury may occur.



# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

## GRIZZLY MODEL G1012 18" BANDSAW

Design Type:.....Floor Model

### Overall Dimensions:

Table .....18" x 18" x 1½"  
 Height from Floor to Table.....38"  
 Height Overall .....71"  
 Width Overall .....33"  
 Depth Overall.....26"  
 Shipping Weight .....350 lbs.  
 Weight in Place .....266 lbs.  
 Crate Size .....18" x 26" x 60"  
 Foot Print .....24½" x 20½"

### Cutting Capacity:

Left of Blade .....17¾"  
 Height .....10"  
 Table Tilt .....5° L 45° R

### Construction:

Table .....Precision Ground Cast Iron  
 Body .....Cast Iron  
 Wheels .....Fully Balanced Cast Aluminum with Rubber Tires  
 Rip Fence .....Double Lock, Adjustable, Extruded Aluminum Guide  
 Wheel Covers .....Pre-Formed Steel  
 Blade Guides .....Steel Blocks With Rear Ball Bearing Support

### Motor:

Type .....TEFC Capacitor Start Induction  
 Horsepower.....2 H.P.  
 Phase / Cycle .....Single Phase / 60 Hz  
 Switch .....220V Magnetic w/ Thermal Overload Protection  
 Voltage .....110/220V-rewired 220V  
 Amps .....12 / 24  
 R.P.M. ....3450  
 Bearings .....Shielded and Permanently Lubricated Ball

### Blade:

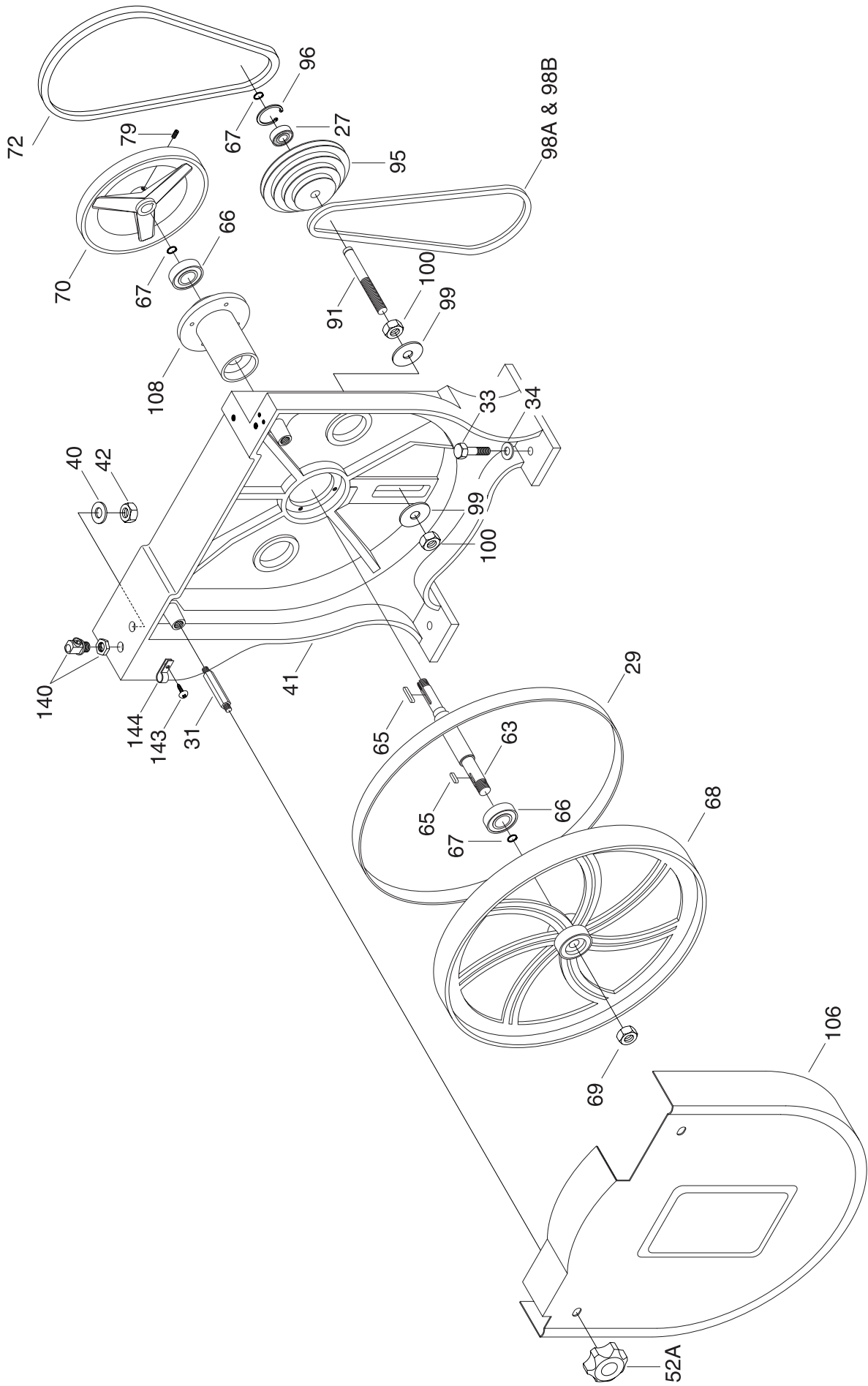
Sizes Available .....1/8" - 1¼"  
 Standard Blade Length .....124"  
 Blade Speeds .....2100 F.P.M., 2600F.P.M., 3150 F.P.M.

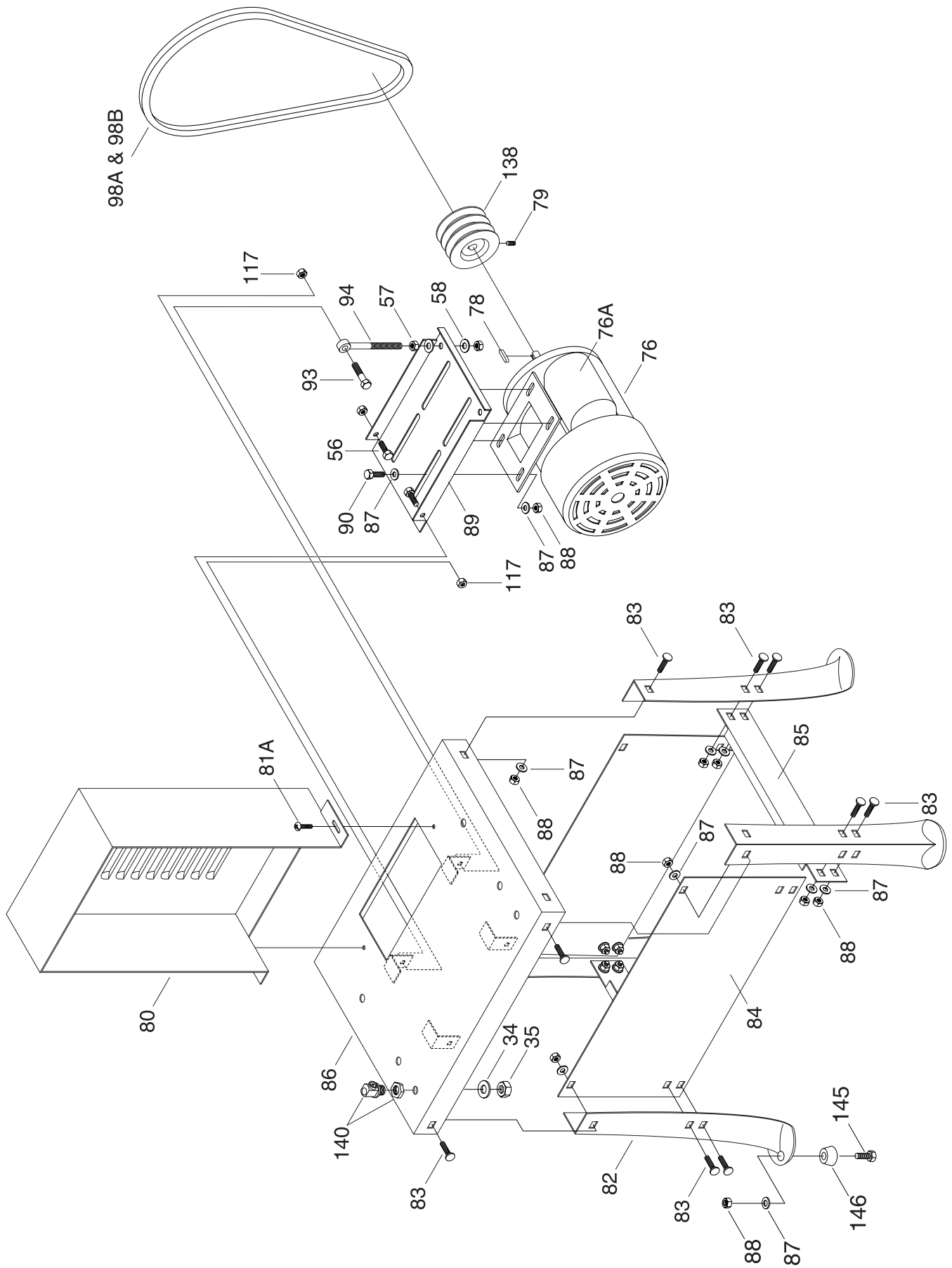
### Accessories:

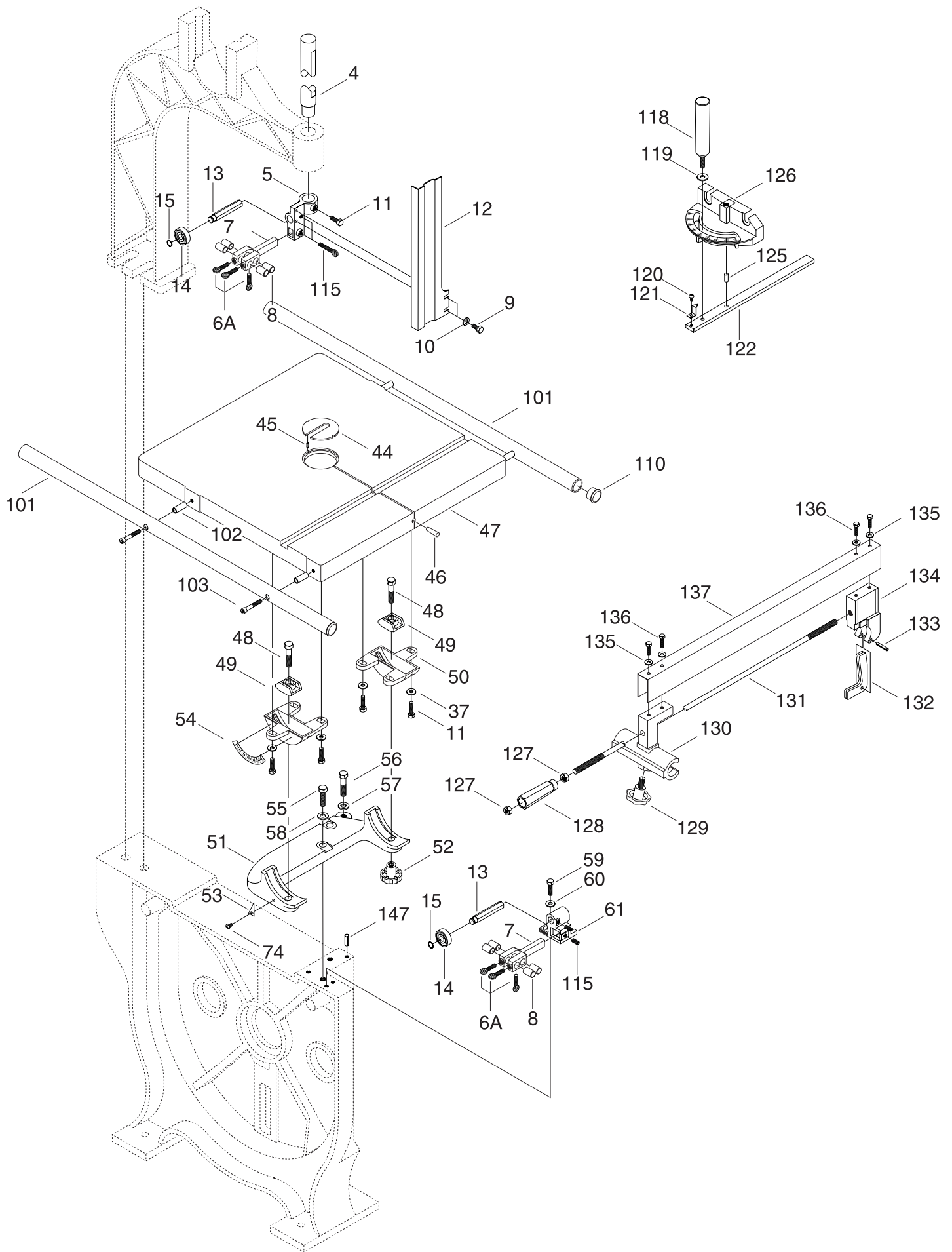
.....Includes: Fence, Miter Gauge & 1" Blade

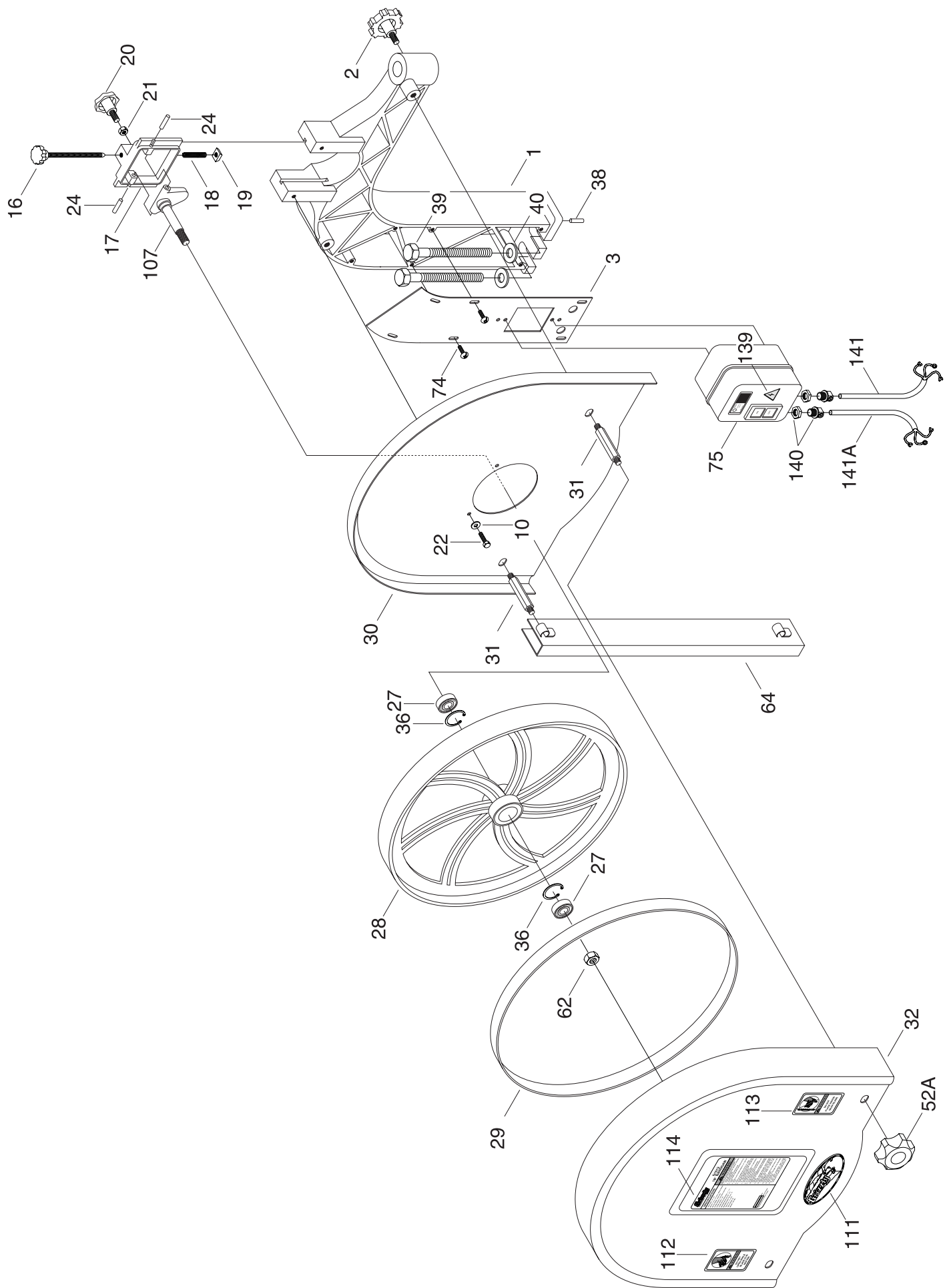
Specifications, while deemed accurate, are not guaranteed.











| REF | PART #    | DESCRIPTION                |
|-----|-----------|----------------------------|
| 001 | P1012001  | UPPER FRAME ARM            |
| 002 | P1012002  | LOCK KNOB                  |
| 003 | P1012003  | SWITCH PLATE               |
| 004 | P1012004  | GUIDE POST                 |
| 005 | P1012005  | SUPPORT BRACKET 7/8" I.D.  |
| 06A | P1012006  | THUMB SCREW 1/4"-20 X 3/8" |
| 007 | P1012007  | GUIDE BLOCK HOLDER         |
| 008 | P1012008  | ROUND GUIDE BLOCK          |
| 009 | PB51      | HEX BOLT 1/4"-20 X 3/8"    |
| 010 | PW06      | FLAT WASHER 1/4"           |
| 011 | PB05      | HEX BOLT 1/4"-20 X 3/4"    |
| 012 | P1012012  | GUARD PLATE                |
| 013 | P1012013  | HEX SHAFT                  |
| 014 | P6200     | BALL BEARING 6200          |
| 015 | PR01M     | EXT RETAINING RING 10MM    |
| 016 | P1019Z033 | BLADE ADJUSTING SCREW      |
| 017 | P1012017  | UPR WHEEL SLIDING BRKT     |
| 018 | P1012018  | SPRING                     |
| 019 | P1019017  | SQUARE NUT 3/8"-16         |
| 020 | P1019018  | ADJUSTMENT KNOB            |
| 021 | PN02      | HEX NUT 5/16"-18           |
| 022 | PB51      | HEX BOLT 1/4"-20 X 3/8"    |
| 024 | P1019021  | STEEL PIN                  |
| 025 | PRP16M    | ROLL PIN 3 X 25            |
| 027 | P6202     | BALL BEARING 6202ZZ        |
| 028 | P1012028  | UPPER WHEEL                |
| 029 | P1012029  | WHEEL PROTECTOR            |
| 030 | P1012030  | UPPER WHEEL GUARD (IN)     |
| 031 | P1012031  | STUD                       |
| 032 | P1012032  | UPPER WHEEL GUARD (O)      |
| 033 | PB41      | HEX BOLT 1/2"-12 X 1 1/2"  |
| 034 | PW01      | FLAT WASHER 1/2"           |
| 035 | PN06      | HEX NUT 1/2"-12            |
| 036 | PR21M     | INT. RETAINING RING 35MM   |
| 037 | PW06      | FLAT WASHER 1/4"           |

| REF | PART #    | DESCRIPTION               |
|-----|-----------|---------------------------|
| 038 | P1012038  | PIN                       |
| 039 | P1012039  | HEX BOLT 5/8"-11 X 2 1/2" |
| 040 | PW14      | FLAT WASHER 5/8"          |
| 041 | P1012041  | BASE                      |
| 41A | P1012041A | BEARING HOUSING           |
| 042 | PN04      | HEX NUT 5/8"-11           |
| 044 | P1012044  | TABLE INSERT              |
| 45A | PRP44M    | ROLL PIN 3 X 10           |
| 046 | P1012046  | TAPERED PIN               |
| 047 | P1012047  | TABLE                     |
| 048 | PB35      | HEX BOLT 3/8"-16 X 2 1/2" |
| 049 | P1012049  | TRUNNION CLAMP SHOE       |
| 050 | P1012050  | TRUNNION                  |
| 051 | P1012051  | TRUN SUPPORT BRACKET      |
| 052 | P1012052  | LOCK KNOB FOR TABLE       |
| 52A | P1012052A | COVER KNOB                |
| 053 | P1012053  | INDICATOR                 |
| 054 | P1012054  | GAUGE                     |
| 55A | PB06      | HEX BOLT 5/16"-16 X 2"    |
| 056 | P1012056  | HEX BOLT 3/8"-16          |
| 057 | PN08      | HEX NUT 3/8"-16           |
| 058 | PW02      | FLAT WASHER 3/8"          |
| 059 | PB05      | HEX BOLT 1/4"-20 X 3/4"   |
| 061 | P1012061  | LOWER SUPPORT BRACKET     |
| 062 | PN01      | HEX NUT 1/2"-20           |
| 063 | P1012063  | LOWER WHEEL SHAFT         |
| 064 | P1012064  | BLADE COVER               |
| 065 | PK35M     | KEY 5 X 5 X 20            |
| 066 | P6205     | BALL BEARING 6205         |
| 067 | PR01M     | EXT RETAINING RING 25MM   |
| 068 | P1012068  | LOWER WHEEL               |
| 069 | P1012069  | SPECIAL LEFT-HAND NUT     |
| 070 | P1012070  | LARGE PULLEY              |
| 072 | PVA32     | V-BELT A-32               |
| 074 | P1012074  | PAN HEAD SCREW            |

| REF  | PART #    | DESCRIPTION                   |
|------|-----------|-------------------------------|
| 075  | P1012075  | SWITCH                        |
| 076  | P1012076  | MOTOR                         |
| 76A  | P1012076A | CAPACITOR COVER               |
| 76C  | PC400S    | CAPACITOR                     |
| 078  | PK23M     | KEY 5 X 5 X 25                |
| 079  | PSS11     | SET SCREW 1/4"-20 X 1/4"      |
| 080  | P1012080  | PULLEY GUARD                  |
| 81A  | PS04      | PHLP HD SCR                   |
| 082  | P1012082  | STAND FOOT                    |
| 083  | PCB02     | CARRIAGE BOLT 5/16"-18 X 1/2" |
| 084  | P1012084  | ADJUSTING PLATE – LONG        |
| 085  | P1012085  | ADJUSTING PLATE – SHORT       |
| 086  | P1012086  | STAND                         |
| 087  | PW07      | FLAT WASHER 5/16"             |
| 088  | PN08      | HEX NUT 5/16" - 18            |
| 089  | P1012089  | MOTOR BASE                    |
| 090  | PB03      | HEX BOLT 5/16"-18 X 1"        |
| 091  | P1012091  | SHAFT                         |
| 092  | P1012092  | HOLDER BASE                   |
| 093  | PB24      | HEX BOLT 3/8"-16 X 1 1/4"     |
| 094  | P1012094  | ADJUSTING ROD                 |
| 095  | P1012094  | PULLEY                        |
| 096  | PR21M     | INT RETAINING RING 35MM       |
| 98A  | PVA31     | V-BELT A-31                   |
| 98B  | PVA33     | V-BELT A-33                   |
| 099  | PW14      | FLAT WASHER 5/8"              |
| 100  | PN04      | HEX NUT 5/8" - 11             |
| 101  | P1012101  | FENCE RAIL                    |
| 102  | P1012102  | FENCE RAIL SPACER             |
| 103A | PSB62     | CAP SCREW 1/4"-20 X 1 1/2"    |
| 106  | P1012106  | LOWER WHEEL GUARD             |
| 107  | P1012107  | UPPER HINGE ASSEMBLY          |
| 108  | P1012108  | LOWER BEARING HOUSING         |
| 110  | P1012110  | RAIL PLUG                     |

| REF  | PART #    | DESCRIPTION                |
|------|-----------|----------------------------|
| 111  | PLABEL-8  | GRIZZLY LOGO PLATE         |
| 112  | P1073171  | DO NOT OPEN LABEL          |
| 113  | P1073170  | HANDS/BLADE LABEL          |
| 114  | P1012114  | WARNING/ID LABEL           |
| 115  | PTS006    | THUMB SCREW 1/4"-20 X 3/4" |
| 117  | PLN01     | LOCK NUT 3/8-16            |
| 118  | P1012118  | MITER GAUGE HANDLE         |
| 119  | P1012119  | SPECIAL WASHER             |
| 120  | PS18      | PHLP HD SCR 10-24 X 1/4"   |
| 121  | P1012121  | INDICATOR                  |
| 122  | P1012122  | GAUGE BAR                  |
| 125  | P1012125  | PIN                        |
| 126  | P1012126  | GAUGE BODY                 |
| 127  | PN08      | HEX NUT 3/8"               |
| 128  | P4186Z308 | REAR LOCK KNOB             |
| 129  | P4186Z310 | FRONT LOCK KNOB            |
| 130  | P4186Z309 | FRONT FENCE CLAMP          |
| 131  | P4186Z306 | CLAMP ROD                  |
| 132  | P4186Z303 | REAR CLAMP                 |
| 133  | P4186Z301 | ROLL PIN                   |
| 134  | P4186Z302 | REAR FENCE BRACKET         |
| 135  | PW06      | FLAT WASHER 1/4"           |
| 136  | PB19      | HEX BOLT 1/4"-20 X 1/2"    |
| 137  | P4186Z300 | FENCE                      |
| 138  | P1012138  | LOWER PULLEY               |
| 139  | P4186Z206 | ELECTRICITY WARNING        |
| 140  | P1012140  | STRAIN RELIEF              |
| 141  | P1012141  | POWER CORD                 |
| 141A | P1012141A | MOTOR CORD                 |
| 143  | PS06      | PHLP HD SCR 10-24 X 3/8"   |
| 144  | P1012144  | CORD CLIP                  |
| 145  | PB03      | HEX BOLT 5/16"-18 X 1"     |
| 146  | P1012146  | RUBBER FEET                |
| 147  | PRP52M    | ROLL PIN 6 X 16MM          |

# TROUBLESHOOTING

|  |   |   |
|--|---|---|
| Motor will not start.  | <ol style="list-style-type: none"> <li>1. Low voltage.</li> <li>2. Open circuit in motor or loose connections.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Check power line for proper voltage.</li> <li>2. Inspect all lead connections on motor for loose or open connections.</li> </ol>  |
| Motor will not start; fuses or circuit breakers blow.  | <ol style="list-style-type: none"> <li>1. Short circuit in line cord or plug.</li> <li>2. Short circuit in motor or loose connections.</li> <li>3. Circuit Overloaded.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Inspect cord or plug for damaged insulation and shorted wires.</li> <li>2. Inspect all connections on motor for loose or shorted terminals or worn insulation.</li> <li>3. Reduce load on circuit.</li> </ol>                       |
| Motor fails to develop full power (power output of motor decreases rapidly with decrease in voltage at motor terminals). | <ol style="list-style-type: none"> <li>1. Power line overloaded with lights, appliances, and other motors.</li> <li>2. Undersized wires or circuits too long.</li> <li>3. General overloading of power company facilities.</li> </ol>                                     | <ol style="list-style-type: none"> <li>1. Reduce load on power line.</li> <li>2. Increase wire sizes or reduce length of wire.</li> <li>3. Request a power check from the power company.</li> </ol>   |
| Motor overheats.   | <ol style="list-style-type: none"> <li>1. Motor overloaded.</li> <li>2. Air circulation through the motor restricted.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Reduce load on motor.</li> <li>2. Clean out motor to provide normal air circulation.</li> </ol>   |
| Motor stalls (resulting in blown fuses or tripped circuit).  | <ol style="list-style-type: none"> <li>1. Short circuit in motor or loose connections.</li> <li>2. Low voltage.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> <li>4. Motor overloaded.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Inspect connections on motor for loose or shorted terminals or worn insulation.</li> <li>2. Correct the low voltage conditions.</li> <li>3. Install correct fuses or circuit breakers.</li> <li>4. Reduce load on motor.</li> </ol> |
| Machine slows when operating.  | Applying too much pressure to workpiece.  | Feed workpiece slower.  |
| Blade does not run evenly on wheels or runs off.   | <ol style="list-style-type: none"> <li>1. Tracking is not adjusted properly.</li> <li>2. Wheels are not coplanar.</li> </ol>  | <ol style="list-style-type: none"> <li>1. Adjust tracking.</li> <li>2. Adjust wheel alignment.</li> </ol>   |
| Blade does not cut evenly.   | <ol style="list-style-type: none"> <li>1. Blade is not properly tensioned.</li> <li>2. Wheels are not coplanar.</li> <li>3. Tooth set is uneven.</li> <li>4. Teeth are sharper on one side than the other.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Adjust blade tension.</li> <li>2. Adjust wheel alignment.</li> <li>3. Skew fence to compensate or replace blade.</li> <li>4. Skew fence to compensate or replace blade.</li> </ol>  |
| Blade slows when cutting. Blade makes a squealing noise, especially on start-up.   | <ol style="list-style-type: none"> <li>1. V-belt loose.</li> <li>2. V-belt worn out.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Tighten V-belt.</li> <li>2. Replace V-belt.</li> </ol>  |
| Ticking sound when the saw is running.   | Weld contacting thrust bearing.   | Use the G2516 Stone to smooth and round the back of the blade.  |
| Blade contacting table insert.   | <ol style="list-style-type: none"> <li>1. Excessive side pressure when cutting.</li> <li>2. Table improperly adjusted.</li> <li>3. Opening in insert too narrow.</li> </ol>   | <ol style="list-style-type: none"> <li>1. Reduce side pressure.</li> <li>2. Adjust table.</li> <li>3. File opening in table insert larger.</li> </ol>   |
| Excessive vibration.   | <ol style="list-style-type: none"> <li>1. Rubber pads not installed under stand.</li> <li>2. Wheels not coplanar.</li> <li>3. Tires incorrectly installed.</li> <li>4. Worn out V-belt.</li> <li>5. Bent or worn out blade.</li> <li>6. Wheels out of balance.</li> </ol> | <ol style="list-style-type: none"> <li>1. Install rubber pads under stand.</li> <li>2. Adjust wheel alignment.</li> <li>3. Re-install tires.</li> <li>4. Replace V-belt.</li> <li>5. Replace blade.</li> <li>6. Replace wheels.</li> </ol>                                    |

# WARRANTY AND RETURNS

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Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.



# WARRANTY CARD

Name \_\_\_\_\_  
Street \_\_\_\_\_  
City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
Phone Number \_\_\_\_\_ E-Mail \_\_\_\_\_ FAX \_\_\_\_\_  
MODEL# \_\_\_\_\_ SERIAL# \_\_\_\_\_ Order # \_\_\_\_\_

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

CUT ALONG DOTTED LINE

- How did you learn about us?  
 Advertisement                       Friend  
 Catalog                                 Card Deck  
 World Wide Web  
  
 Other \_\_\_\_\_
- Which of the following magazines do you subscribe to.  
 American Woodworker                 Practical Homeowner  
 Cabinetmaker                           Shop Notes  
 Family Handyman                       Today's Homeowner  
 Fine Homebuilding                     WOOD  
 Fine Woodworking                     Wooden Boat  
 Home Handyman                         Woodshop News  
 Journal of Light Construction        Woodsmith  
 Old House Journal                     Woodwork  
 Popular Mechanics                     Woodworker  
 Popular Science                         Woodworker's Journal  
 Popular Woodworking                 Workbench  
 Other \_\_\_\_\_
- Which of the following woodworking/remodeling shows do you watch?  
 Backyard America                       The New Yankee Workshop  
 Home Time                                This Old House  
 The American Woodworker           Woodwright's Shop  
 Other \_\_\_\_\_
- What is your annual household income?  
 \$20,000-\$29,999                       \$60,000-\$69,999  
 \$30,000-\$39,999                       \$70,000-\$79,999  
 \$40,000-\$49,999                       \$80,000-\$89,999  
 \$50,000-\$59,999                       \$90,000 +
- What is your age group?  
 20-29                                       50-59  
 30-39                                       60-69  
 40-49                                       70 +
- How long have you been a woodworker?  
 0 - 2 Years                                8 - 20 Years  
 2 - 8 Years                                20+ Years
- How would you rank your woodworking skills?  
 Simple                                       Advanced  
 Intermediate                               Master Craftsman
- What stationary woodworking tools do you own? Check all that apply.  
 Air Compressor                         Panel Saw  
 Band Saw                                   Planer  
 Drill Press                                 Power Feeder  
 Drum Sander                               Radial Arm Saw  
 Dust Collector                           Shaper  
 Horizontal Boring Machine           Spindle Sander  
 Jointer                                       Table Saw  
 Lathe                                         Vacuum Veneer Press  
 Mortiser                                     Wide Belt Sander
- How many of your woodworking machines are Grizzly? \_\_\_\_\_  
 Other \_\_\_\_\_
- Which benchtop tools do you own? Check all that apply.  
 1" x 42" Belt Sander                     6" - 8" Grinder  
 5" - 8" Drill Press                       Mini Lathe  
 8" Table Saw                               10" - 12" Thickness Planer  
 8" - 10" Bandsaw                        Scroll Saw  
 Disc/Belt Sander                         Spindle/Belt Sander  
 Mini Jointer  
 Other \_\_\_\_\_
- How many of the machines checked above are Grizzly? \_\_\_\_\_
- Which portable/hand held power tools do you own? Check all that apply.  
 Belt Sander                                Orbital Sander  
 Biscuit Joiner                           Palm Sander  
 Circular Saw                               Portable Planer  
 Detail Sander                             Saber Saw  
 Drill/Driver                                Reciprocating Saw  
 Miter Saw                                  Router  
 Other \_\_\_\_\_
- What machines/supplies would you like Grizzly Industrial to carry?  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
- What new accessories would you like Grizzly Industrial to carry?  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
- What other companies do you purchase your tools and supplies from?  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
- Do you think your purchase represents good value?  
 Yes     No
- Would you recommend Grizzly Industrial to a friend?  
 Yes     No
- Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**  
 Yes     No
- Comments: \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

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Send a Grizzly Catalog to a friend:

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|----------------------------------|
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| Street _____                     |
| City _____ State _____ Zip _____ |

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